

Date: Wednesday, 3/7/2007 2:26:00 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number : 31048	
Estimate Number : 10799	
P.O. Number : N/A	Part Number : D350600142
This Issue : 3/7/2007	Drawing Number : D3188 /ICA
S.O. No. : N/A	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : C
First Issue : 3/7/2007	Material : N/A
Type : SMALL /MED FAB	Due Date : 3/30/2007
Previous Run : 30625	Qty: 1 Um: Each
Written By : <u>JA 07.03.07</u>	
Checked & Approved By : <u>JA 07.03.07</u>	
Comment : Est Rev:D 06.04.14 Incorporated procedures from D3187-1/-2 K J/JLM Est Rev:E 06-11-20 As per DSI9335 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG0013

SEE ATTACHED

2.0	31048A	SWITCH RELOCATION KIT
-----	--------	-----------------------



Comment: Sub-Component SWITCH RELOCATION KIT

31048A 33436A

3.0	31048B	SPACEPOD BODY RH
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Comment: Sub-Component SPACEPOD BODY RH

D3188-2M Batch: **B 30092***ml 07/07/17*

4.0	31048C	SPACEPOD DOOR RH
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Comment: Sub-Component SPACEPOD DOOR LH

D3186-2 B **30087** 31048C*ml 07/07/17*

5.0	D31872	Spacepod Floor
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-2	Floor	B 25405
1	D3186-2	Door (ref)	B 31048C
1	D3188-2M	Body(ref)	B 30092

✓

ml 07/07/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s) *Washer AN 3235-020-935*

Pick:

Qty Part Number Description Batch

28 ALS4-1032-130 Insert

2ty 8

BM/04760

PTO

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-2 into D3188-2.

2-Open holes in D3188-2 body floor to Ø0.297".

3-Install inserts in D3188-2 as per Dwg D3188.

4-Open holes in D3187-2 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-2

m/07/07/18

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/18 (1)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-2 floor only*****

Chemical Conversion Coat as per QSI 005 4.1

Handy 07-07-19

(1)

10.0

POWDER COATING

POWDER COATING



M102316



(1)

Comment: POWDER COATING

*****D3187-2 floor only*****

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-k 07/07/21

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m/07/07/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/18	6	should read on this step Washers instead of inserts		ml	07/07/18			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A ml 07/07/23

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

5.62SF D2986

Neoprene Foam

B30632

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T2

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch: M102565

ml 07/07/23

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/23 (X)

16.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Insert

batch:

* ⑧
M16197

M103495

17.0

D35672

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch:

M112222

34128

D3567-2

PTO

18.0

MS20426AD45

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

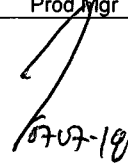
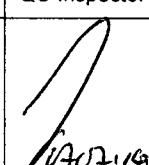
Pick:

Batch:

M3459

6/7/17SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/18	17	Should read: label D3564 - 2 for right hand on -142 only permanent change						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35491

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B31125

20.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Batch: B31692

21.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: B30210

22.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Batch: M104156

23.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Batch: B33423

24.0

MS20426AD46

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivet

Batch: M100151

25.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: B32371

7/7/17 SP

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: 30630

27.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: 9216

28.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M104156

29.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M104012

7/7/17 59

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-2 floor with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for body & floor*

ml07/07/23

31.0

D35529

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B30673

32.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103585

7/7/17 54

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M104156

34.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100993

35.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M104812

36.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: 30684

37.0

D35671

DECAL



D 3567-2



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: M31122

38.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Door Latch

batch: M30880

39.0

D2585

Latch Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Latch Clamp

batch: ~~30716~~

Need 3 B 30814 7/7/17 59

PTO

PTO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/07/18	37	Should read label D3567-2 for right hand on - 142 only Permanent change	ml	07/07/18		<i>[Signature]</i>	<i>[Signature]</i>	
07/07/18	39	change Qty for 3 Permanent change	ml	07/07/18		<i>[Signature]</i>	<i>[Signature]</i>	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 2:26:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Latch Plate

batch: B31111

①
B328916

41.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Screw

batch: M15432

42.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

batch: M104885

43.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit

Nut

batch: M103830

?
102 L58

44.0

D28571



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Hinge Bracket

batch: M31832

45.0

D2228

Backing Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Backing Plate

batch: M230679

46.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

batch: M104603

① *
M103585

7/7/14 SP

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD8

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M104150

48.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M104812

49.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B30718

50.0

D35481

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: 30245

51.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: 30210

52.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: M104156

53.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: 33423

3/7/17 SP

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

ml 07/07/23 (X1)

55.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/24 (X1)

56.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: *M104942*

m-h 07/07/24

57.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

En 07/07/25 (X1 RH)

58.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

*B30869
B25405*

1 D3187-1(Ref)

Spacepod Floor

07/7/26

59.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 07/07/26

60.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-142

Location: *D*

PPP Rev: *D*

En 07/07/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 31048

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 07-07-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

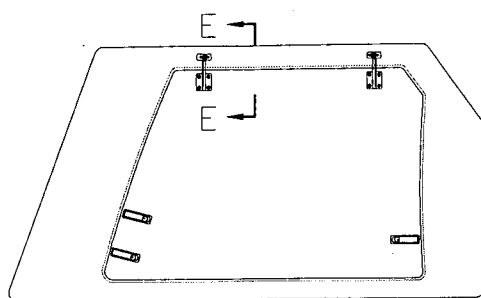


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

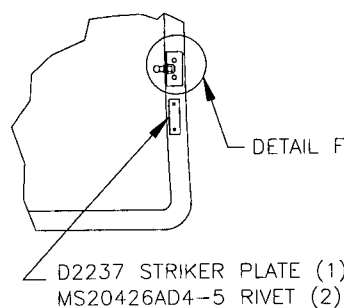


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

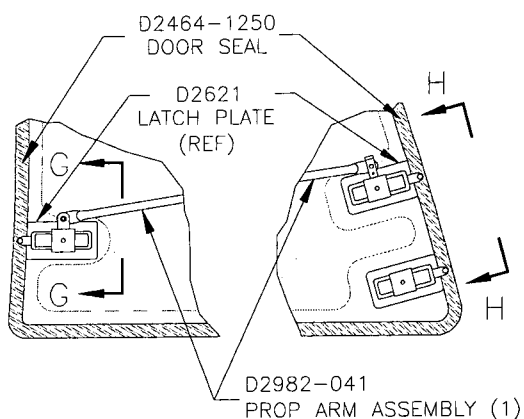
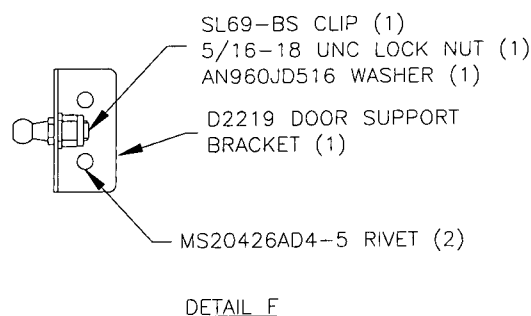


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



TC Accepted
MAY 07 2003

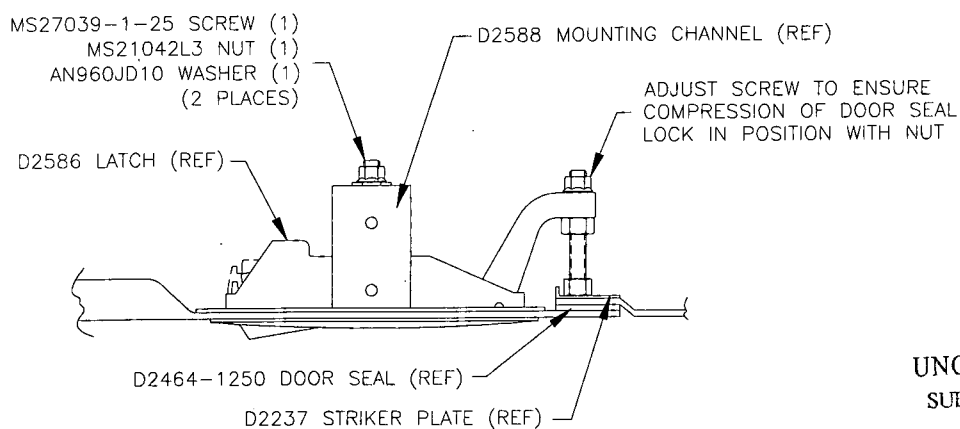
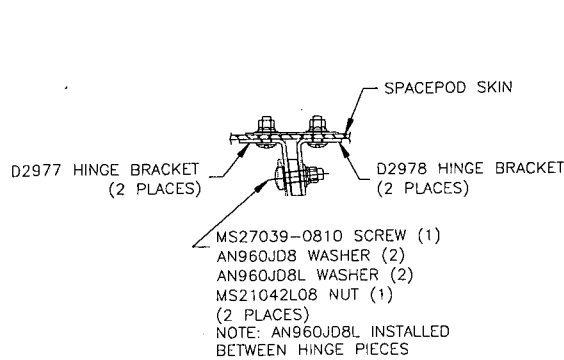


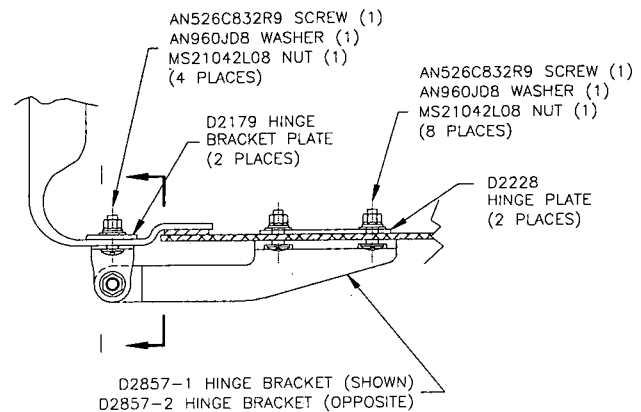
FIGURE 6. TYPICAL LATCH INSTALLATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31048

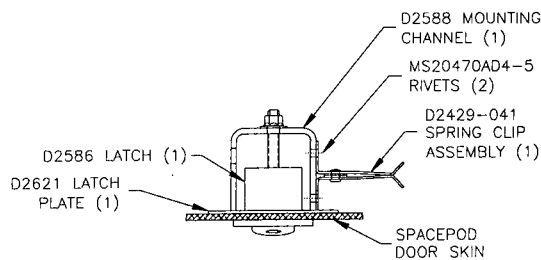
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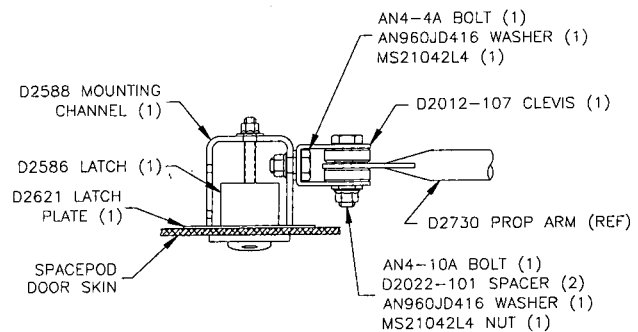
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



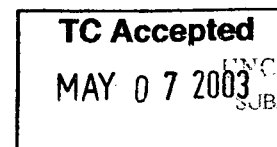
SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.



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WORK ORDER
NO. 31048

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25-00-00

DART

DESIGN	JB	DRAWN BY	CE	DART AEROSPACE LTD
CHECKED	BT	APPROVED	BT	HAWKESBURY, ONTARIO, CANADA
DATE	06.12.13	DATE	06.12.13	REV. C
		TIME	SPACEPOD BODY	SHEET 1 OF 11
A		03.04.03	NEW ISSUE	SCALE
B		06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	NTS
C		06.12.13	REMOVED D0600-XXX LABELS	

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

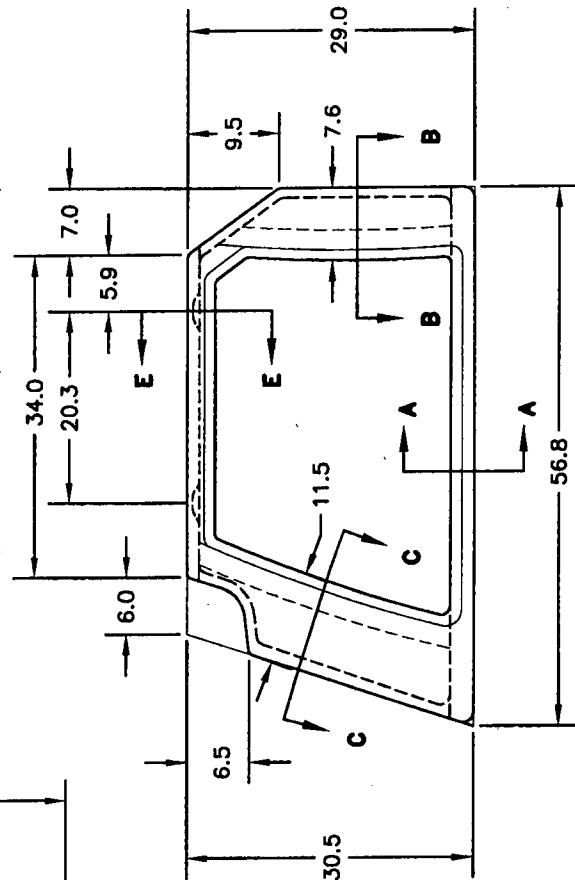
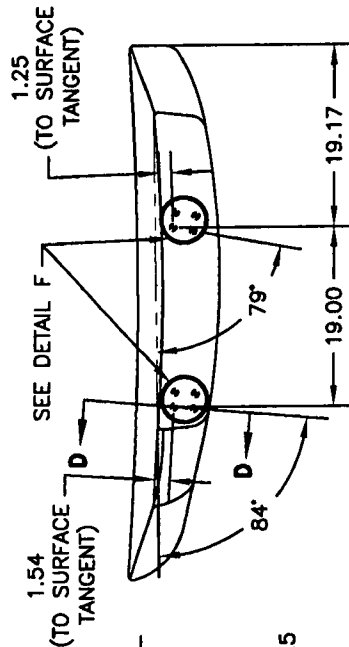
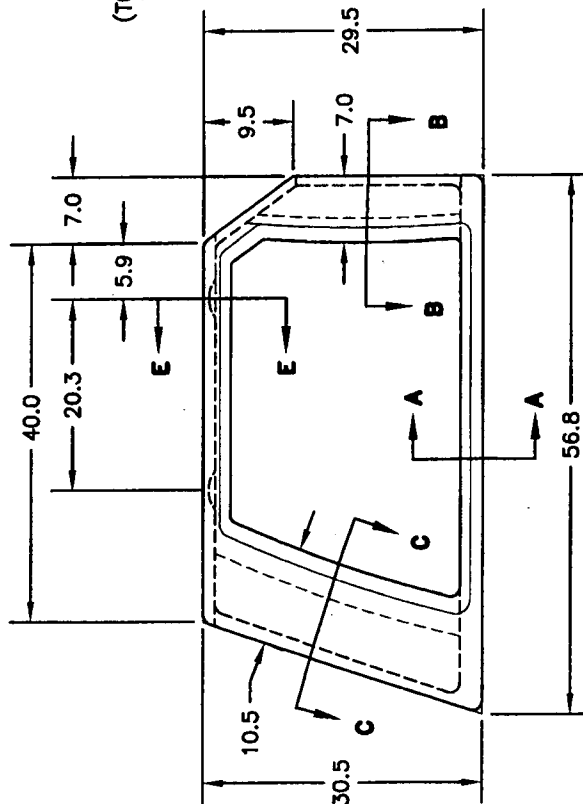
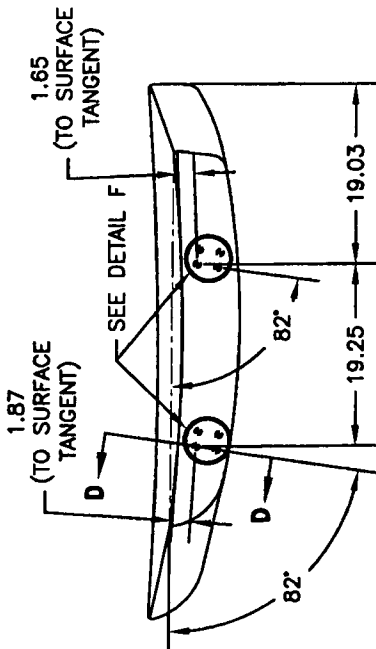
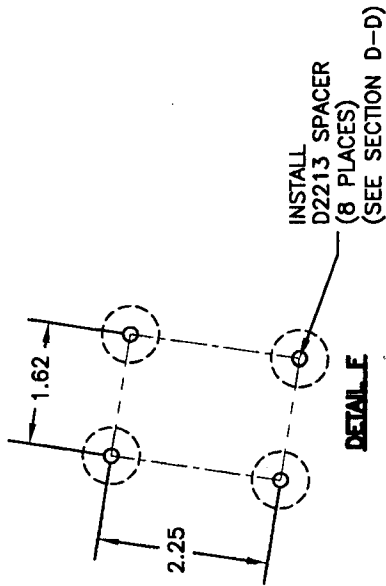
- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 2 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS



D3188-3M SPACEPOD BODY

D3188-1M SPACEPOD BODY

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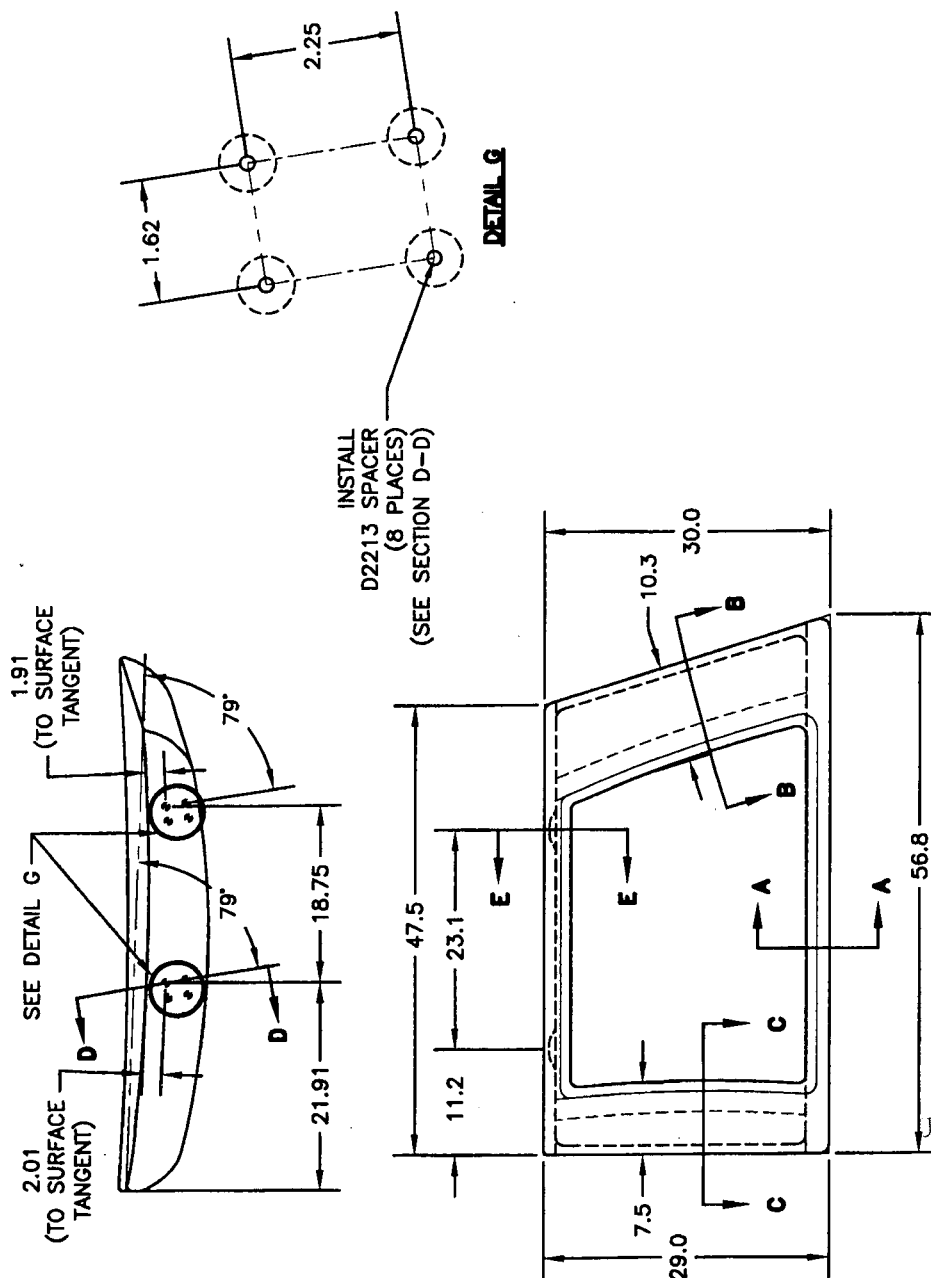
NOTE:
SEE SHEET #4 FOR SECTION VIEWS

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. C SHEET 3 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-2M SPACEPOD BODY

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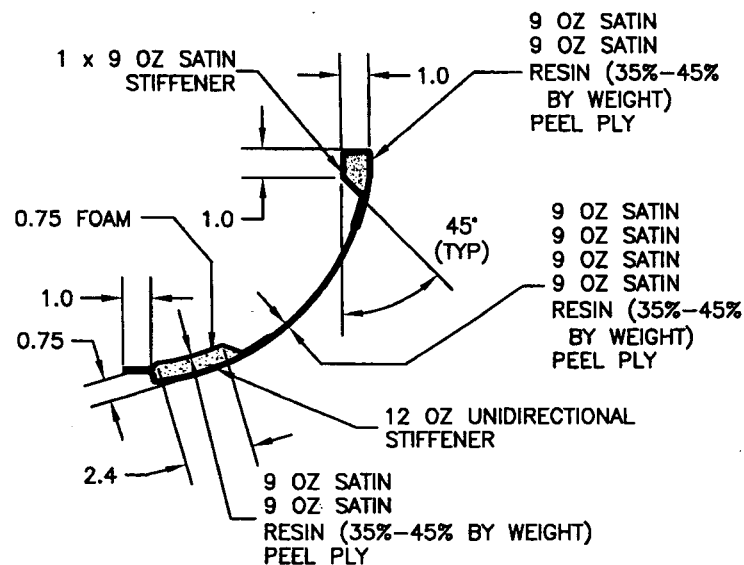
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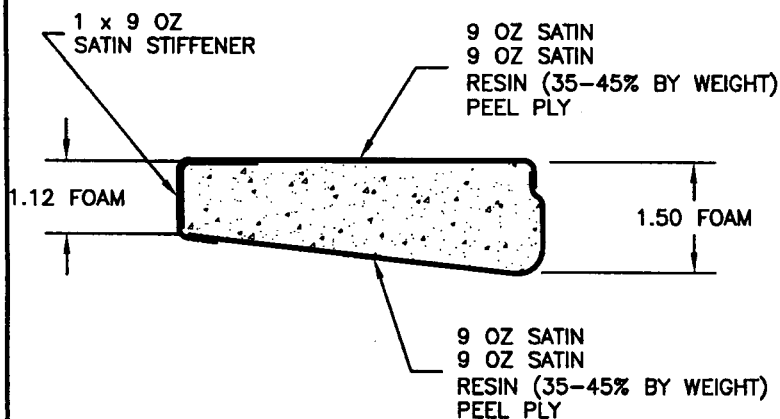
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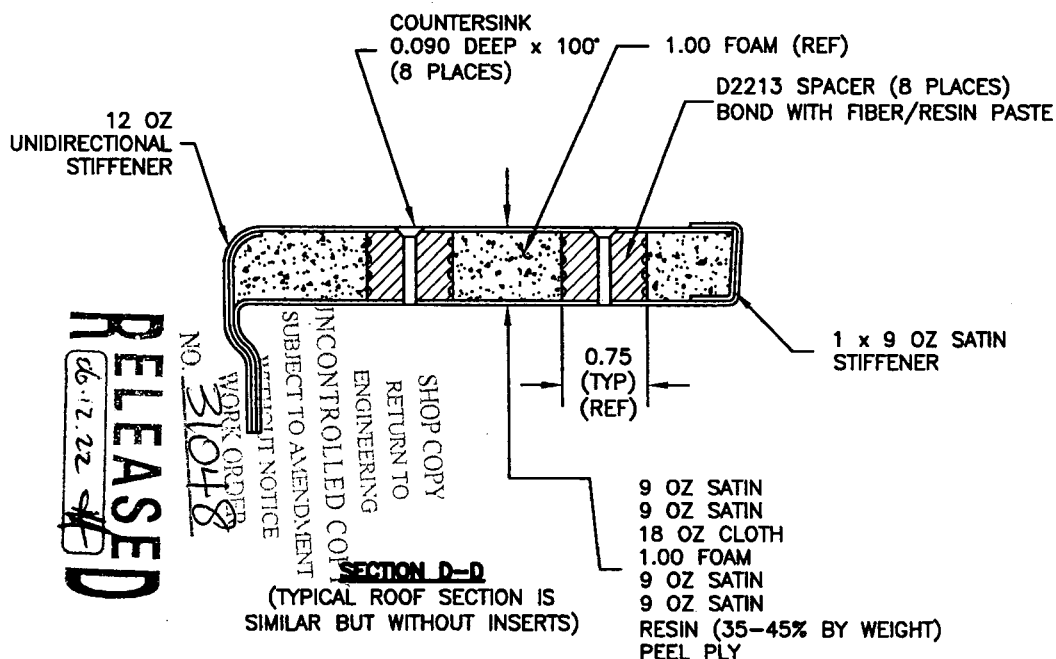
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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.12.13	DRAWING NO.	D3188	REV. C
		TITLE	SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS



SECTION B-B
(SECTION C-C OPPOSITE)

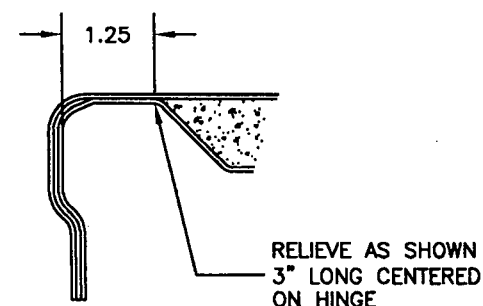


SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D

(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



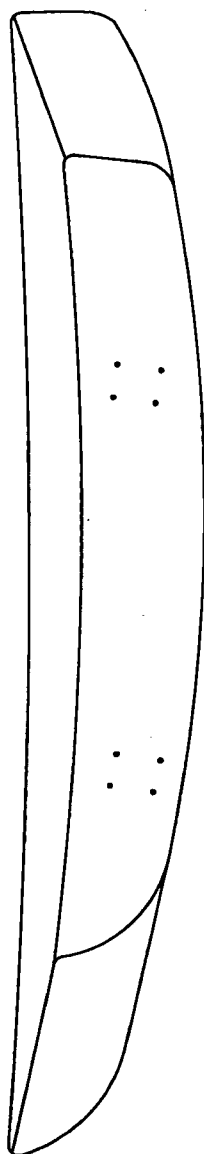
SECTION E-E
(2 PLACES PER POD)

RELEASED
06.12.22

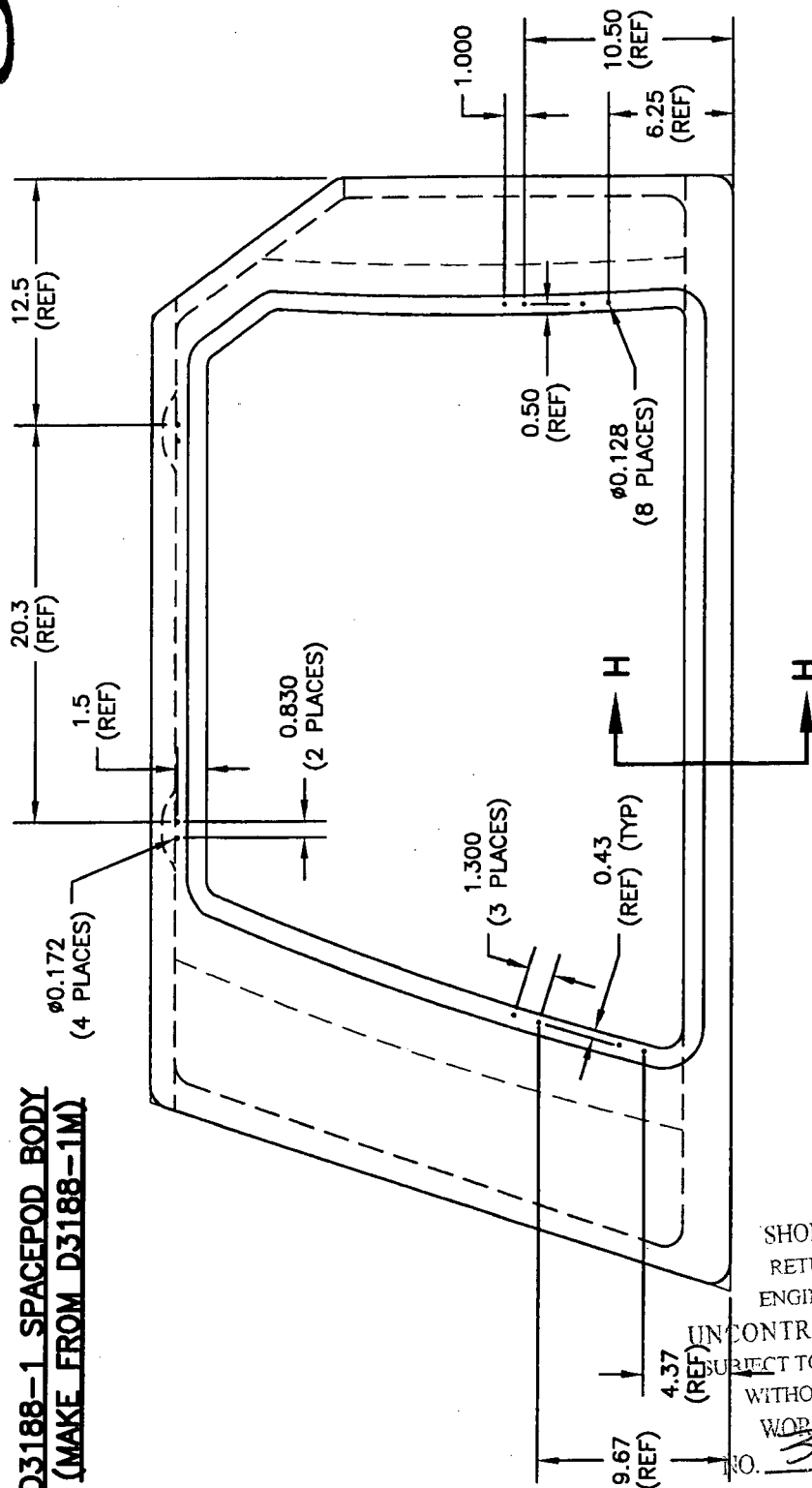


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
02.22



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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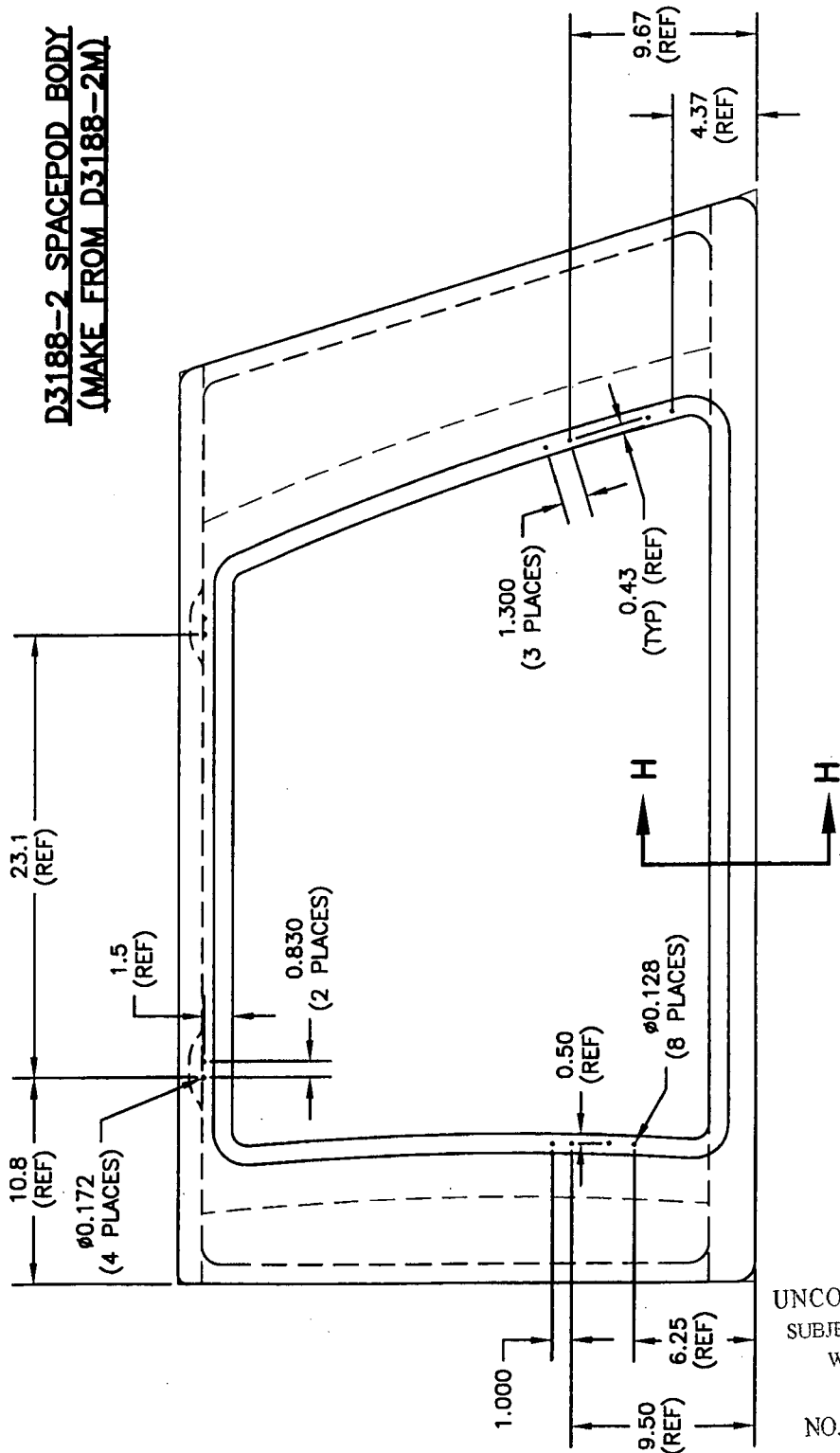
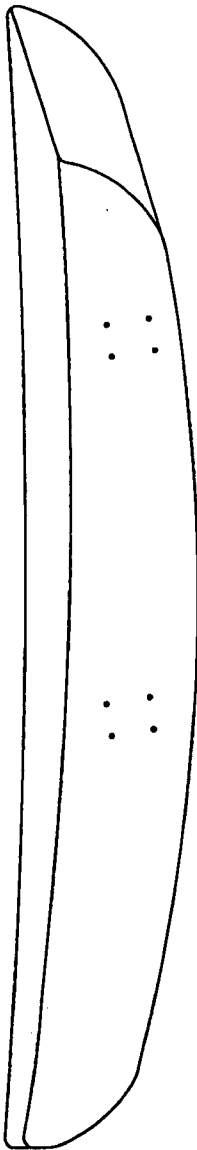
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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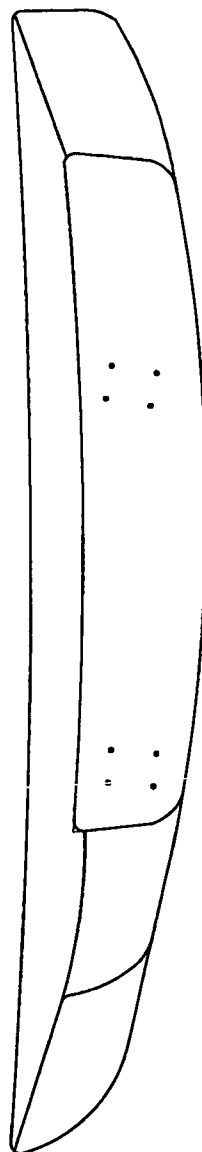
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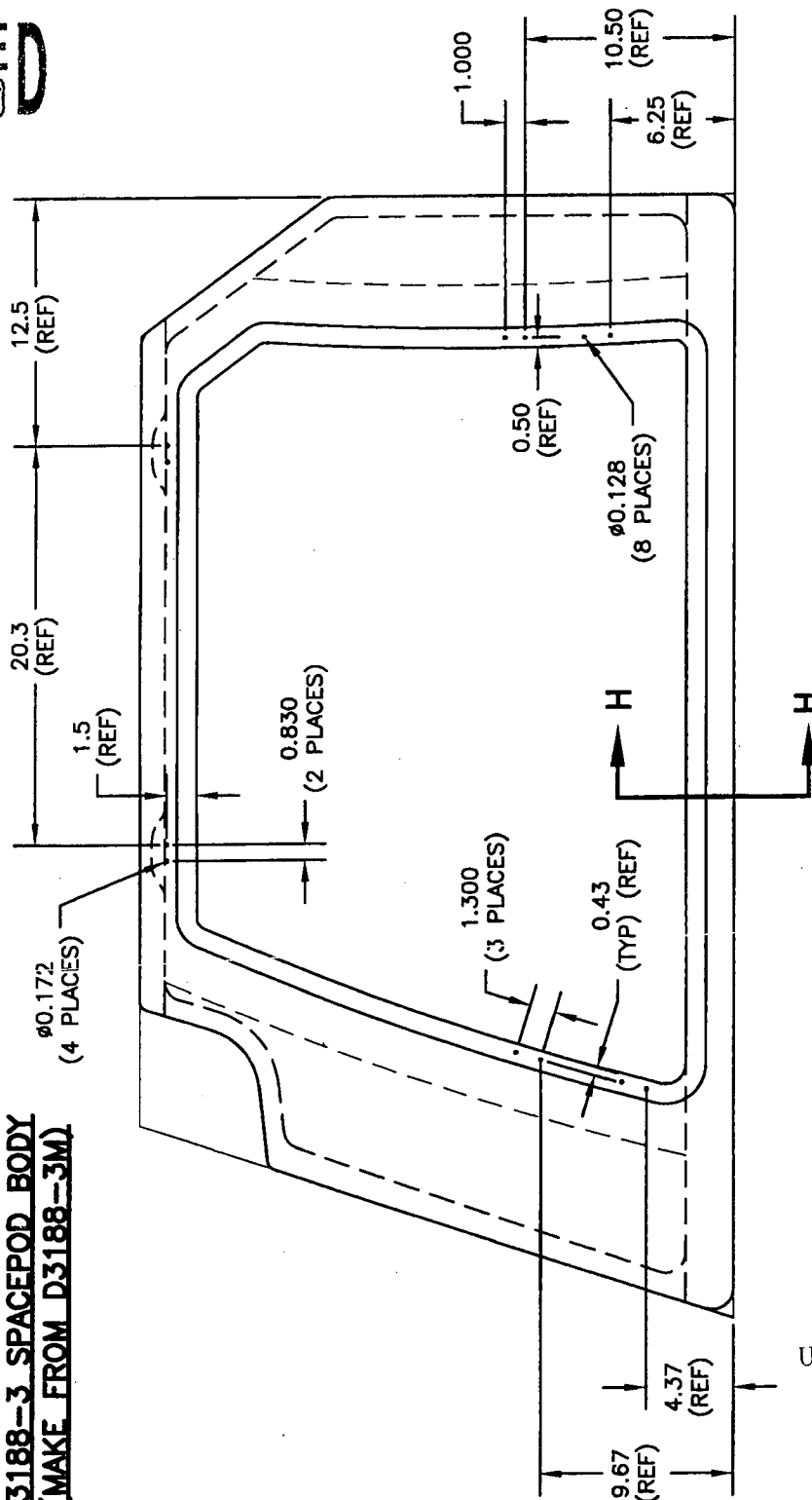


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22



**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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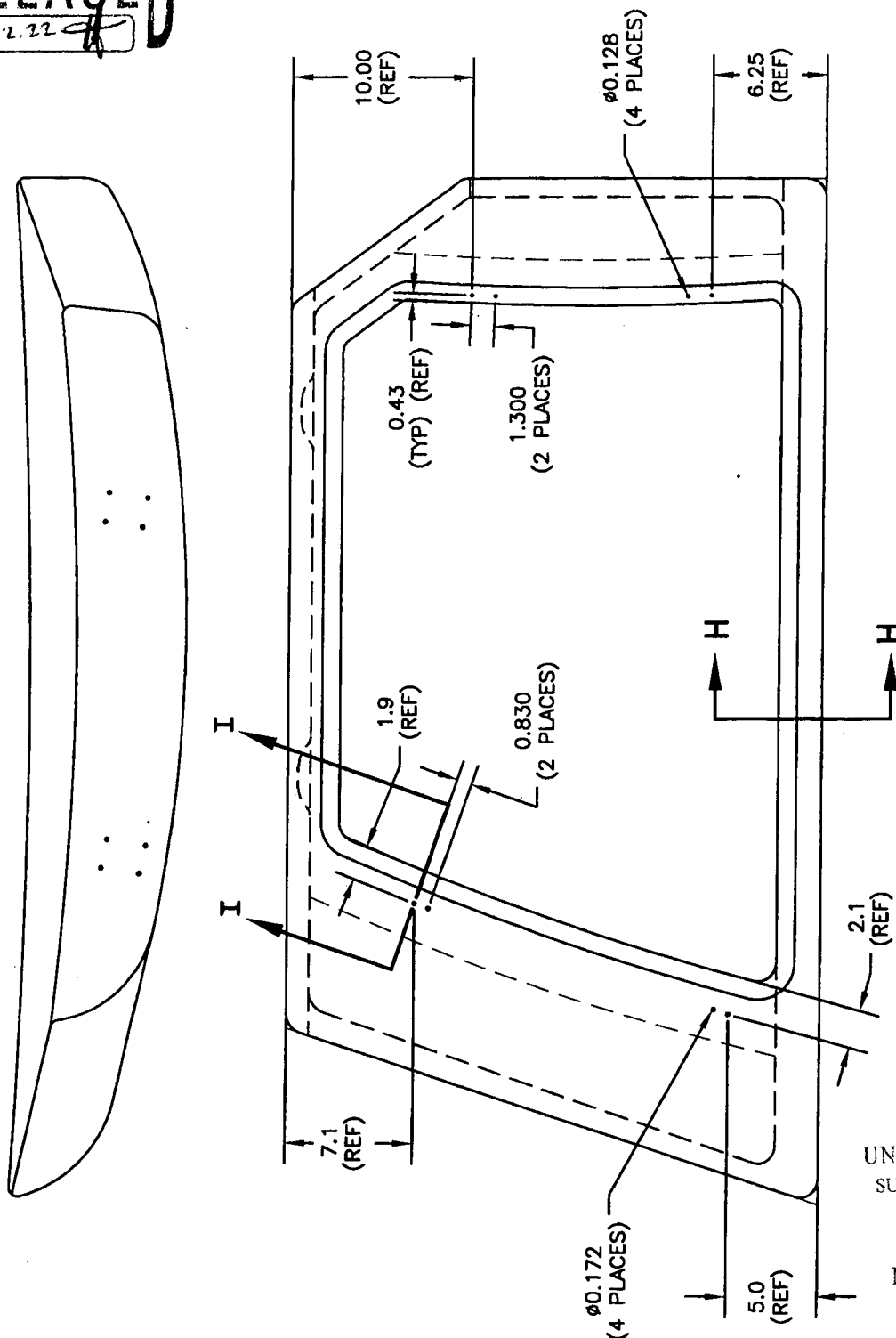
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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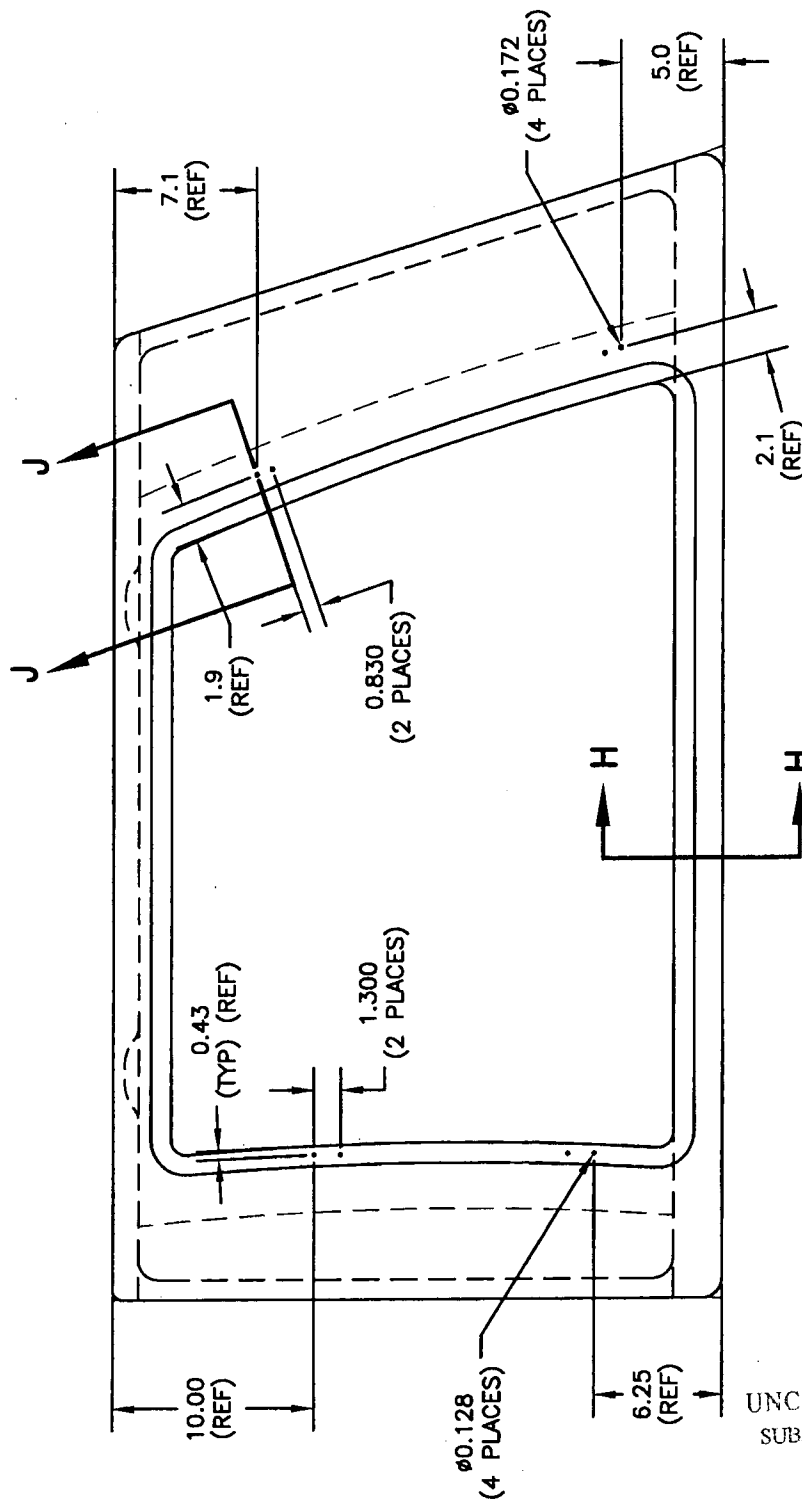
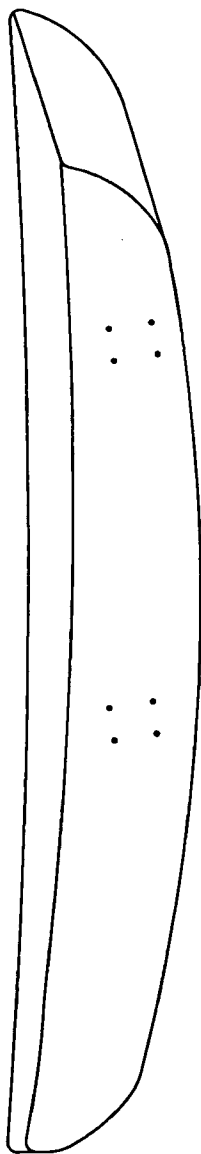
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22 [Signature]

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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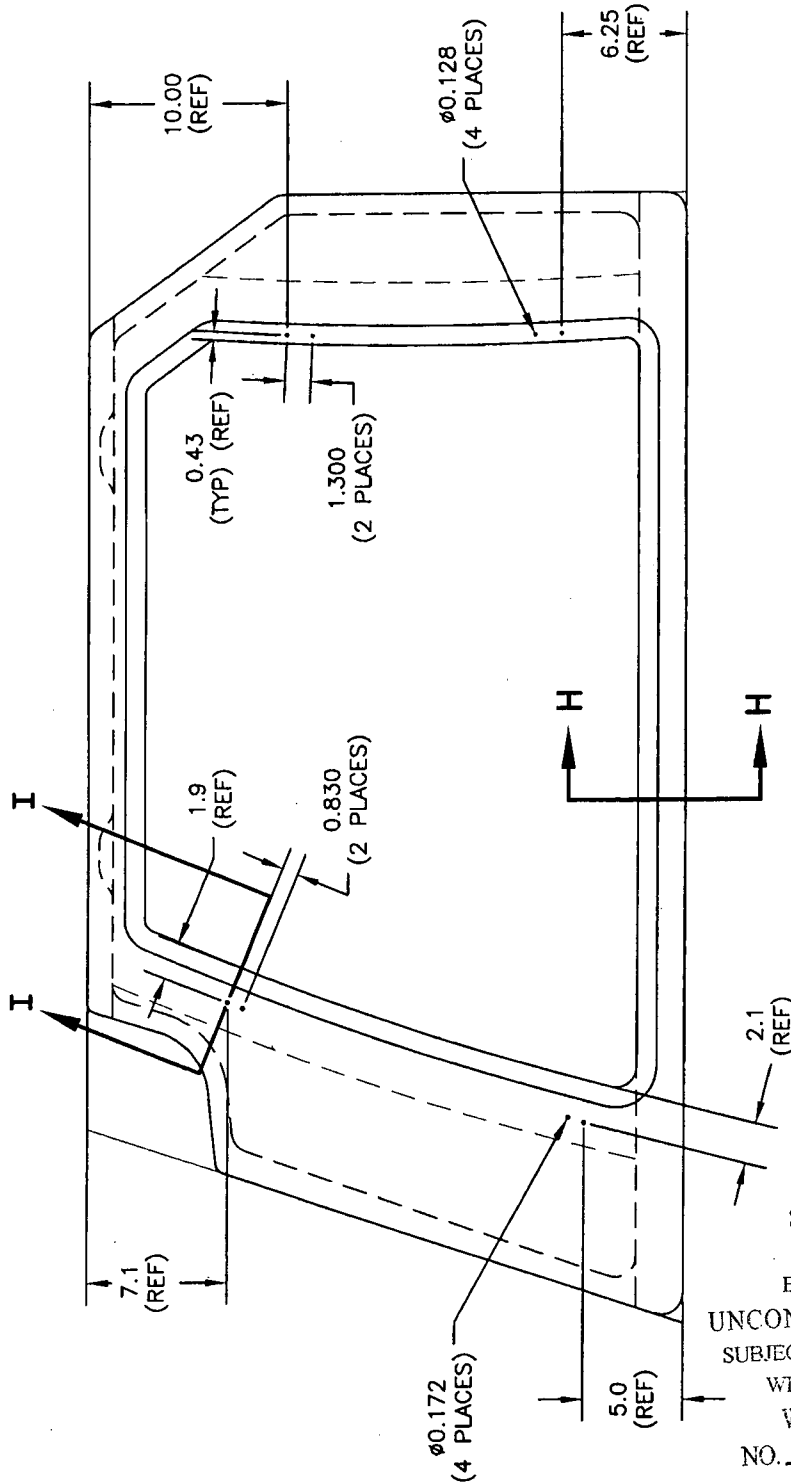
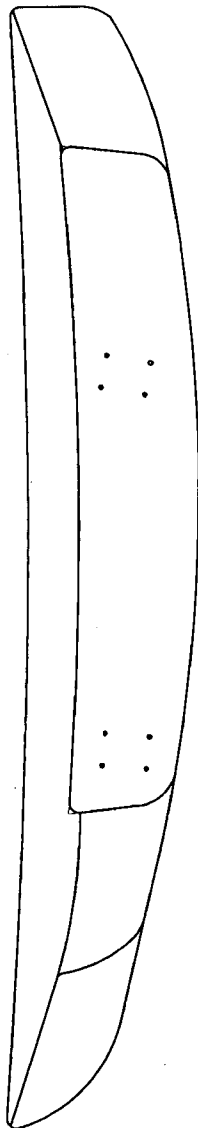
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
a. r. n. [Signature]

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

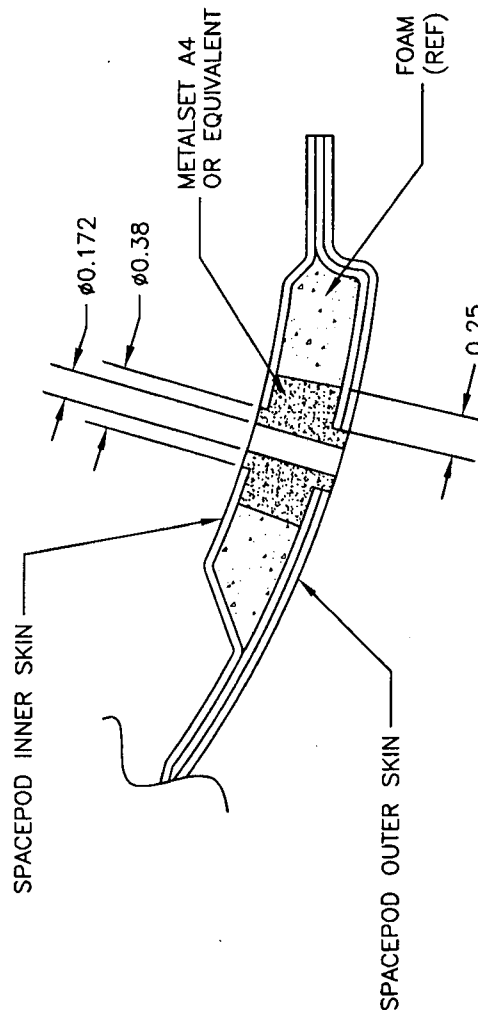
RELEASED
06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Wednesday, 3/7/2007 2:26:00 PM
 User: Kim Johnston

Process Sheet

13

Customer : CU-DAR001: Dart Helicopters Services
 Job Number : 31048
 Estimate Number : 10799
 P.O. Number :
 This Issue : 3/7/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 3/7/2007 Type : SMALL /MED FAB
 Previous Run : 30625
 Written By :
 Checked & Approved By : 07.03.07
 Comment : Est Rev:D 06.04.14 Incorporated procedures from D3187-1/-2 K
 J/JLM
 Est Rev:E 06-11-20 As per DS19335 JLM

Drawing Name : SPACEPOD ASSEMBLY RH/ DSI 9335
 Part Number : D350600142
 Drawing Number : D3188 /ICA
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 3/30/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-142 CHG002 003

New Paperwork / LABELS

07.03.16

2.0

31048A

SWITCH RELOCATION KIT



Comment: Sub-Component SWITCH RELOCATION KIT

3.0

31048B

SPACEPOD BODY RH



Comment: Sub-Component SPACEPOD BODY RH

D3188-2M Batch: _____

4.0

31048C

SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-2 B _____

5.0

D31872

Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-2 Floor _____

1 D3186-2 Door (ref) _____

1 D3188-2M Body(ref) _____

REFERENCE ONLY



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12035
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/06/2007	22/12/2006	5093	C. Lavoie		PO00002771		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30087 Dwg. Rév.: D Job: 41784 U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30092 Dwg. Rév.: D Job: 41312 U de M : Each			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30077 Dwg. Rév.: D Job: 41783 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30082 Dwg. Rév.: D Job: 41303 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

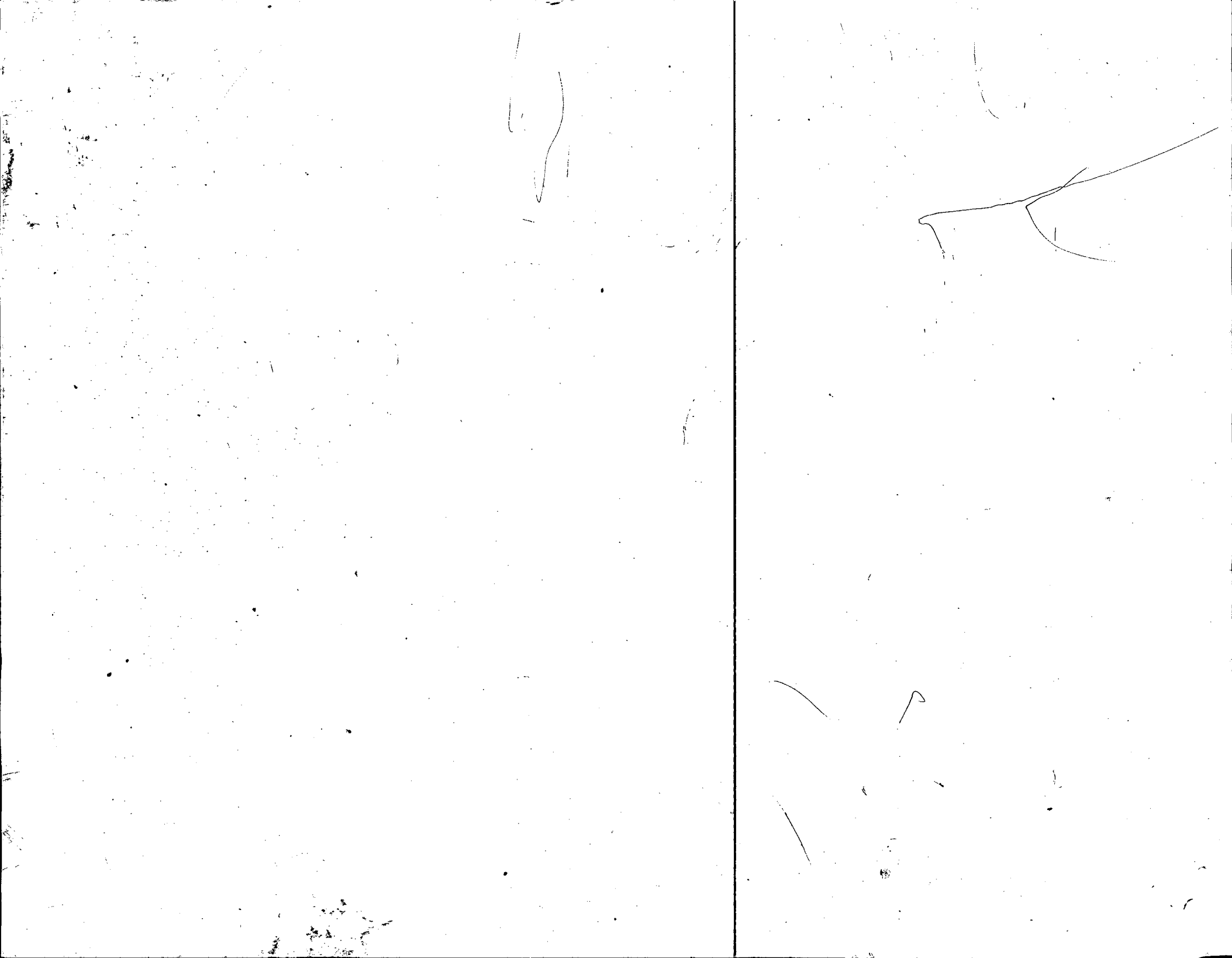
Michael Staud

Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.





Date:
User:Thursday, 12/21/2006 12:55:38 PM
Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD BODY RH
Job Number :	30092		
Estimate Number :	12596		
P.O. Number :	N/A	Part Number :	D31882M
This Issue :	12/21/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3188 REV <i>SC</i> <i>LE</i> 07.01.18
First Issue :	N/A	Project Number :	N/A
Previous Run :	30091	Drawing Revision :	<i>SC</i> <i>LE</i> 07.01.18
	Type :	Material :	N/A
	PURCHASED PARTS	Due Date :	2/28/2007
Written By :		Qty:	1
Checked & Approved By :	<i>HA 061221</i>	Um:	Each
Comment :	Est Rev:A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8	D2213	Spacer	Batch: <i>B 30049</i>
---	-------	--------	-----------------------

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
Issue P/O: *2771* *C2061121220*
Description: D3188-2M BODY
SHIP: D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

07/07/03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/21/2006 12:55:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 30092

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 . Visual inspection. Check for void spot and pins.

ml 07/07/17

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/07/17

7.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

ml 07/07/26

Job Completion



U 07-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D3188
DATE 06.12.13		SHEET 1 OF 11
		SCALE NTS
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN


- MOLD SHEDULE:

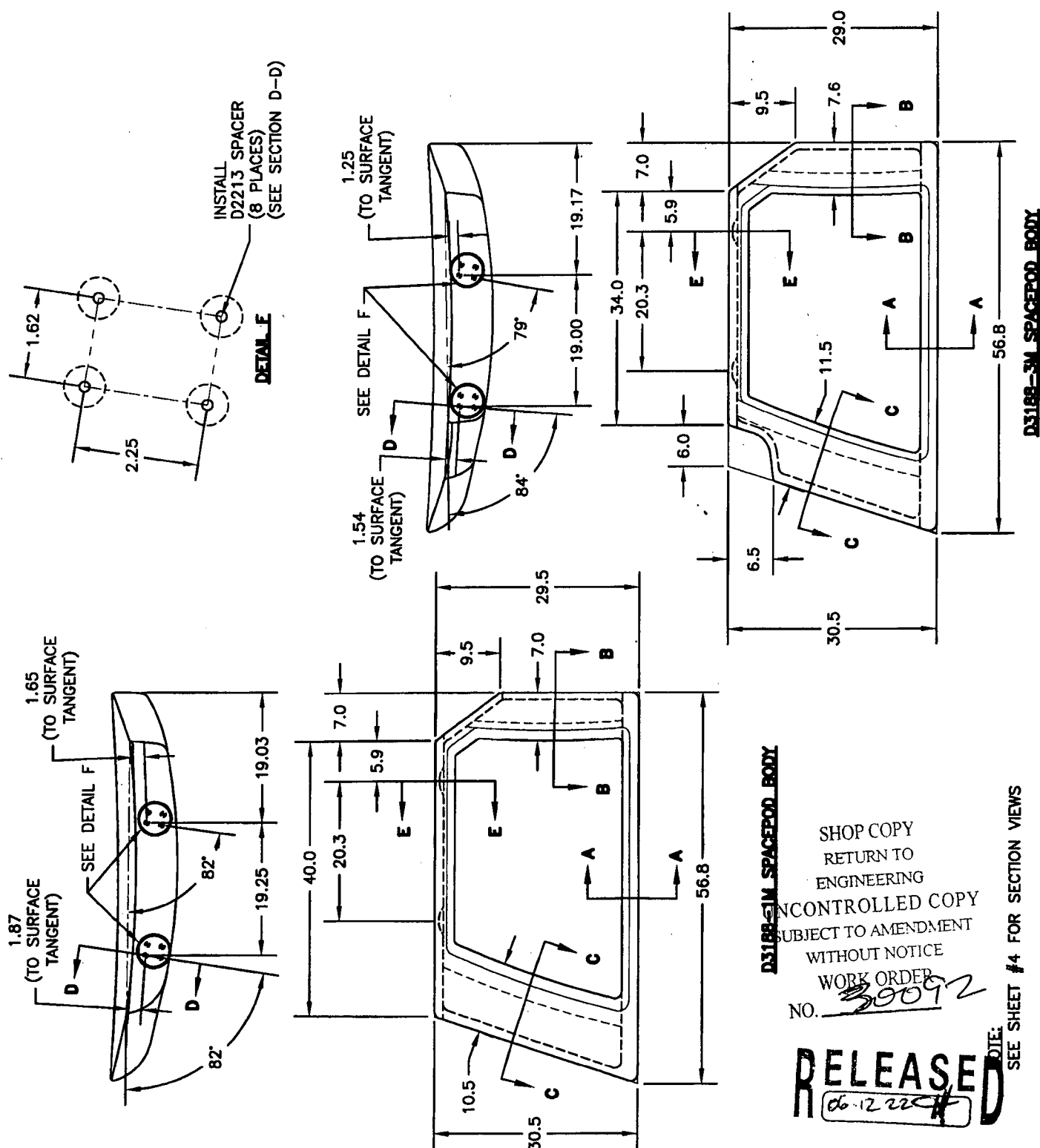
PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 20012

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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

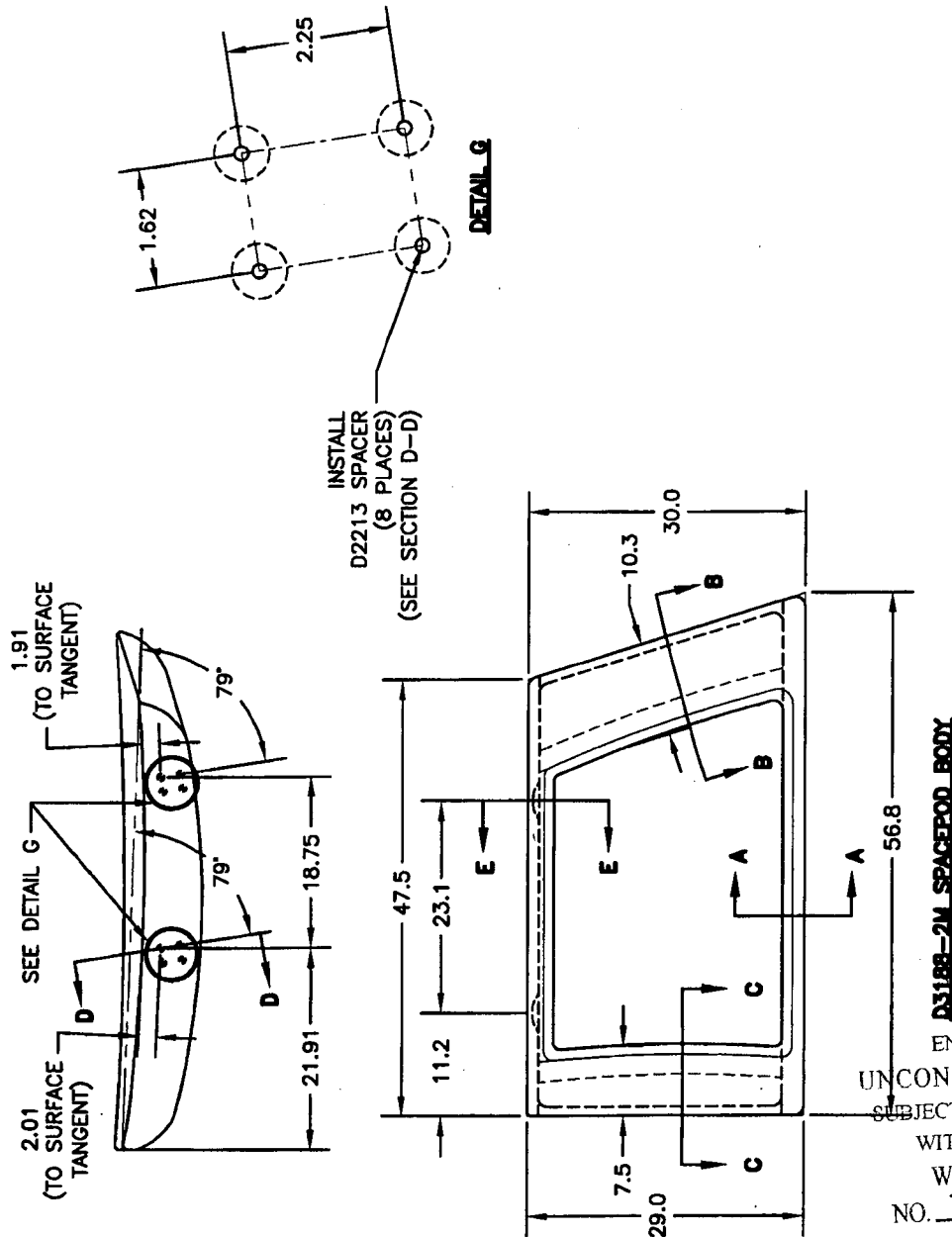


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-2M SPACEPOD BODY

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06.12.22

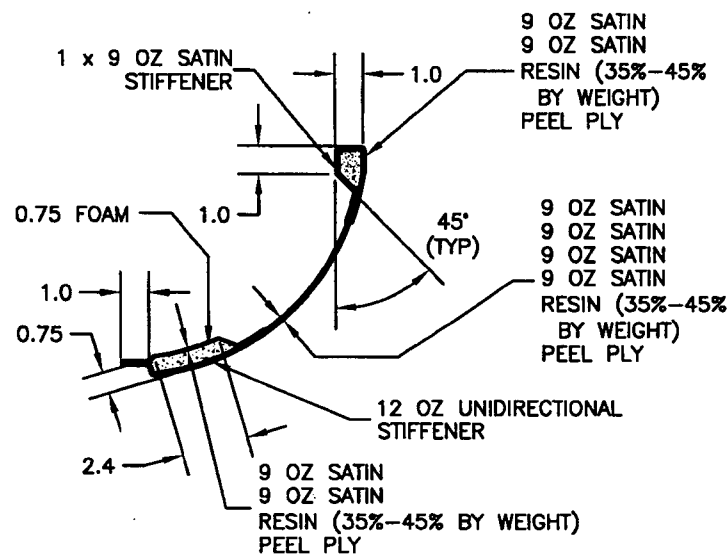
NOTE:
SEE SHEET #4 FOR SECTION VIEWS

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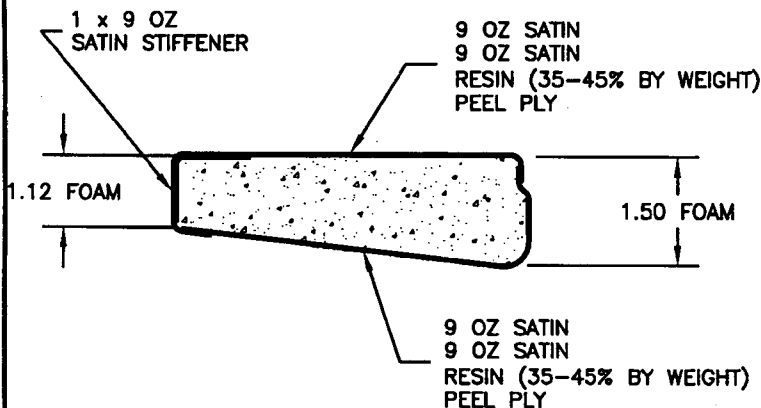
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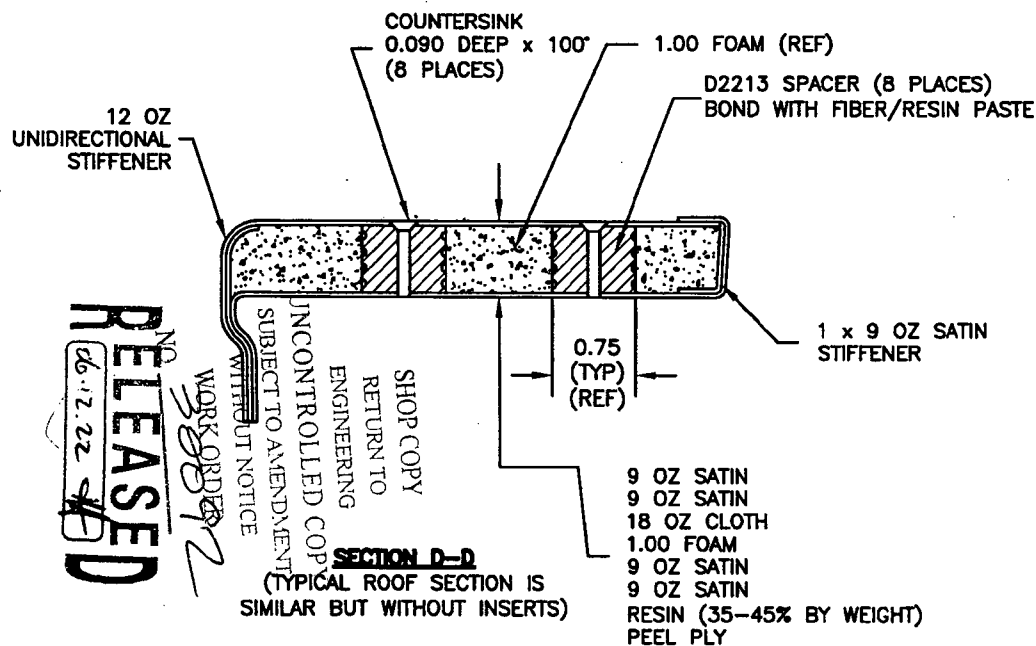
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CHECKED	PH	APPROVED	PH	DRAWING NO.	D3188	SHEET 4 OF 11
DATE	06.12.13	TITLE	SPACEPOD BODY	SCALE	NTS	



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)

RELEASED
NO. 161222
WORK ORDER 38872

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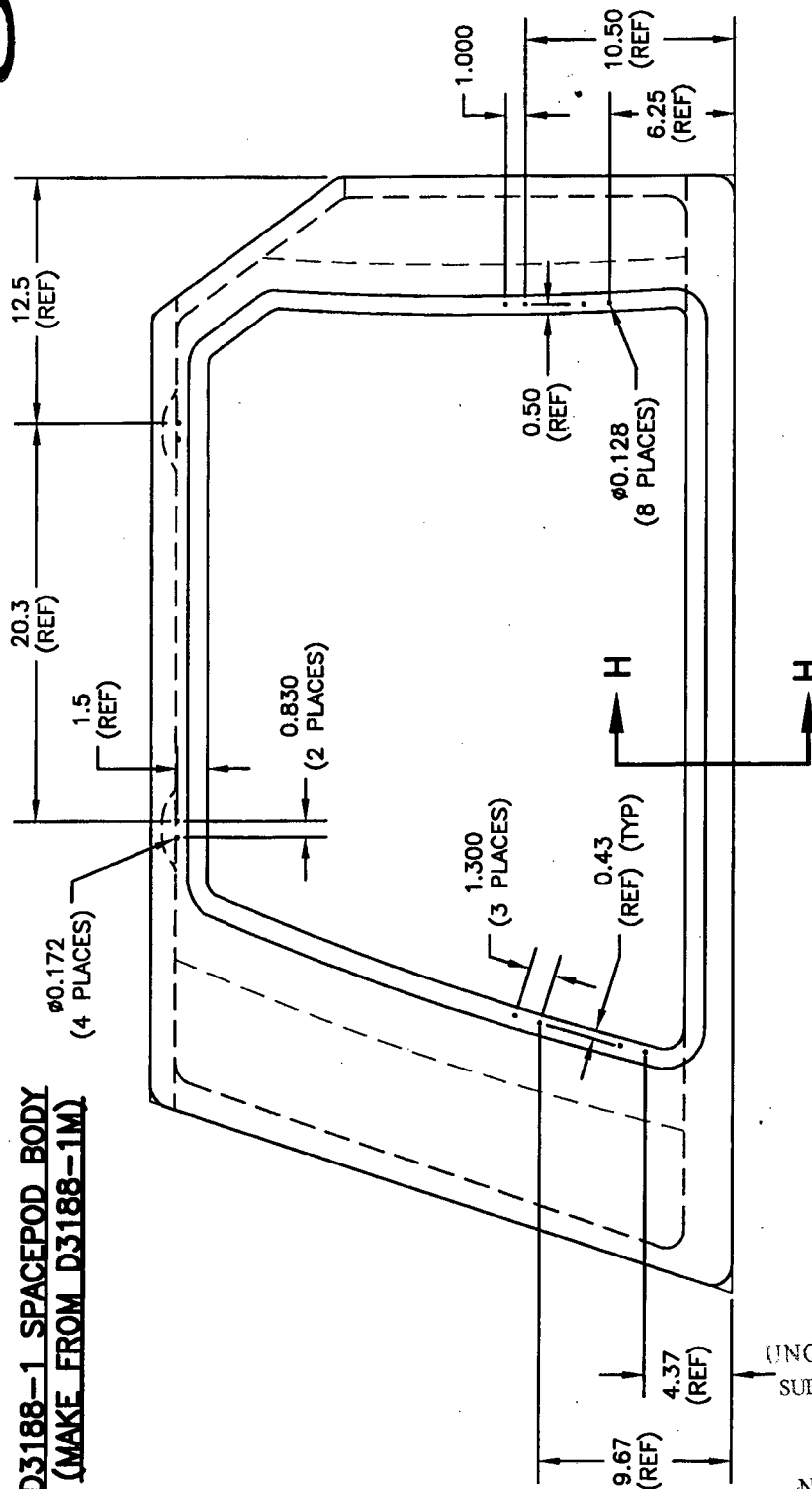


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22



**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

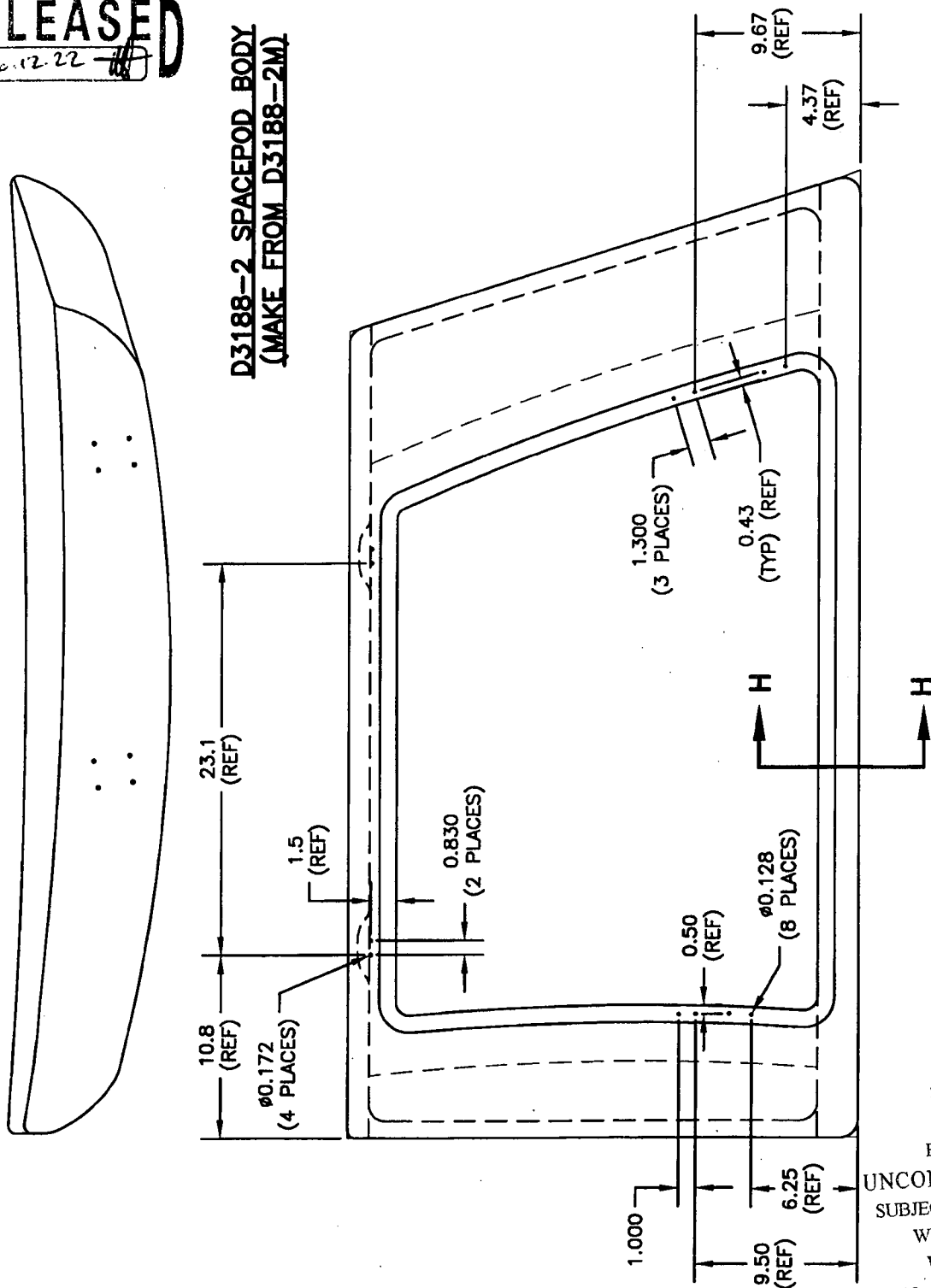
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22**D3188-2 SPACEPOD BODY**
(MAKE FROM D3188-2M)**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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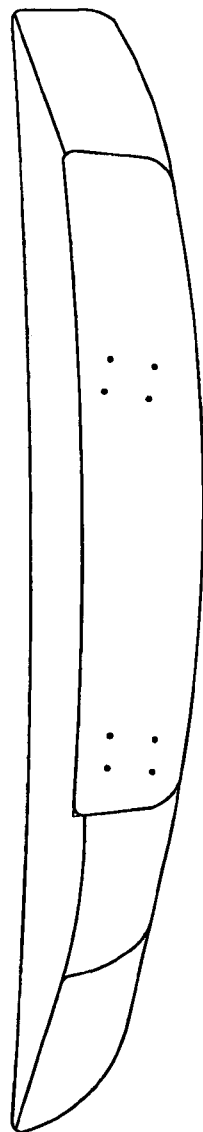
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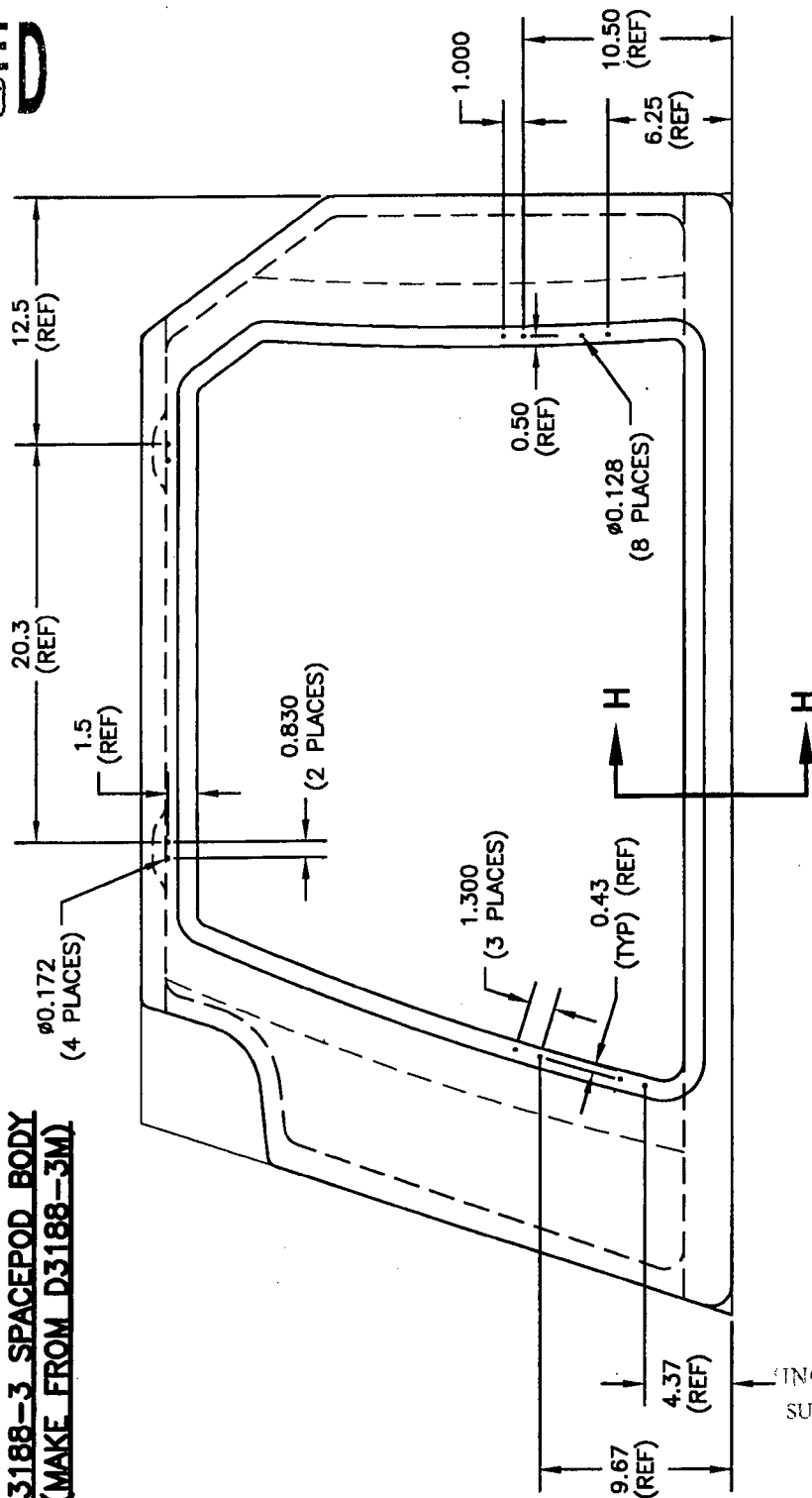


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
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**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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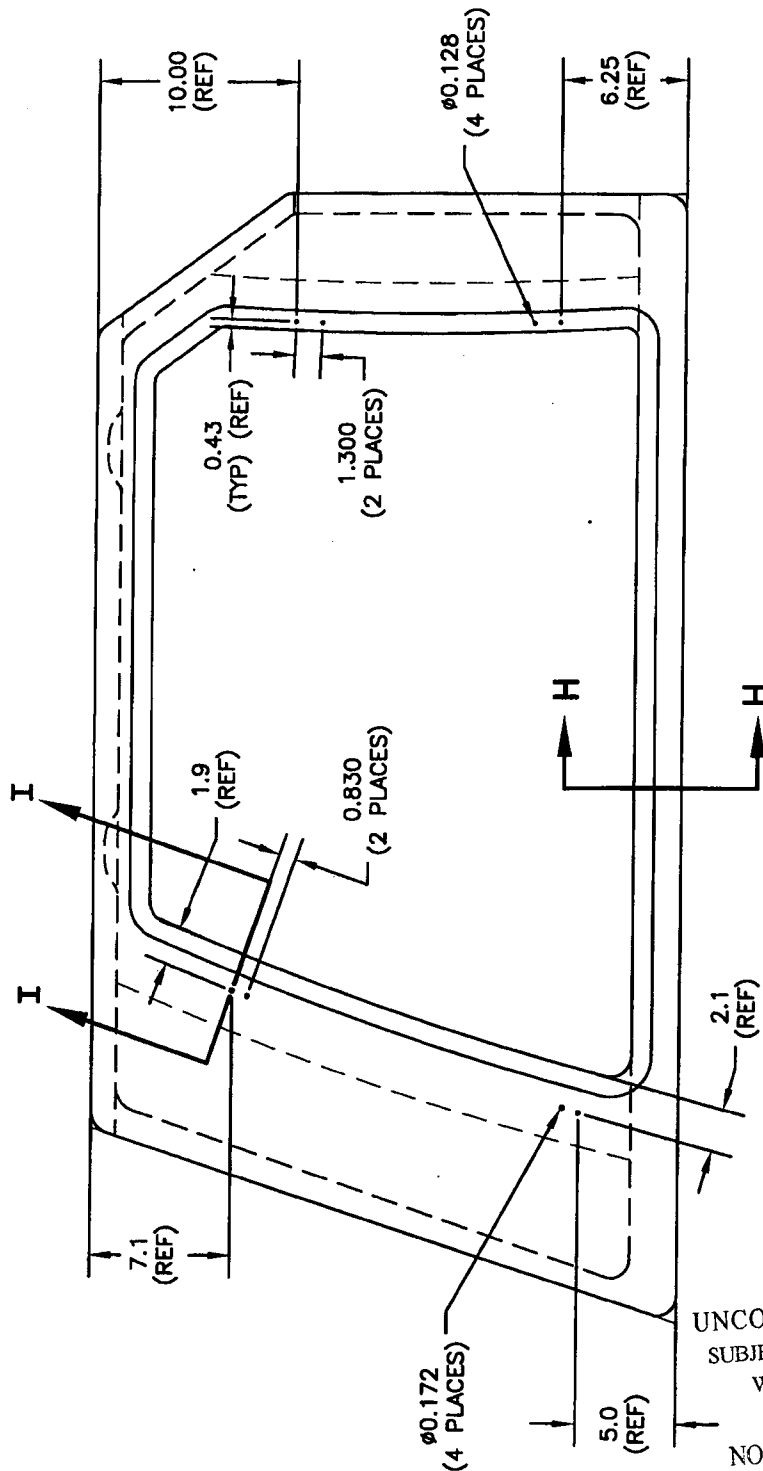
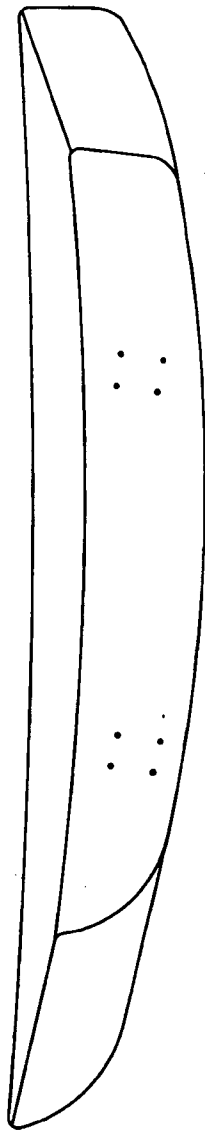
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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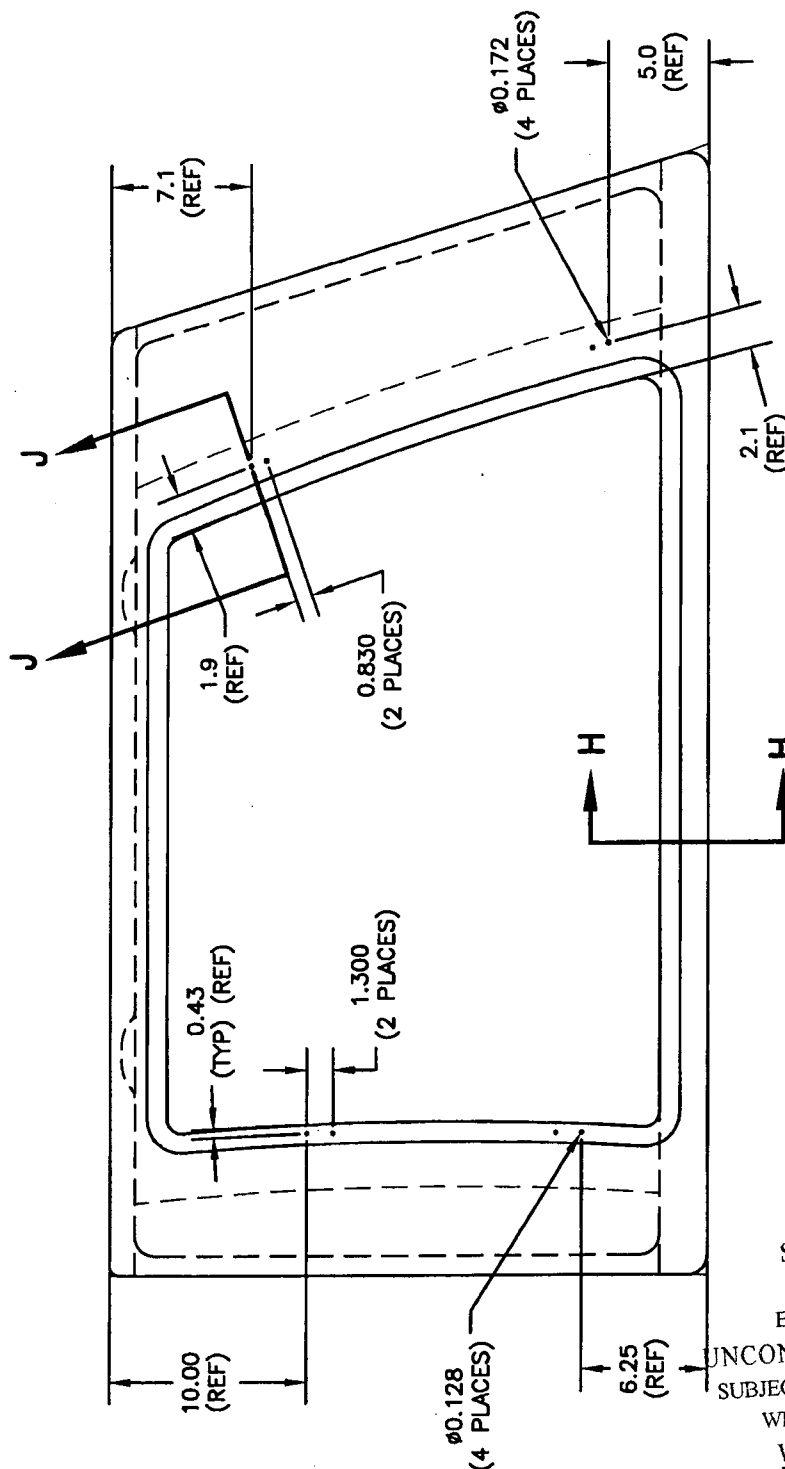
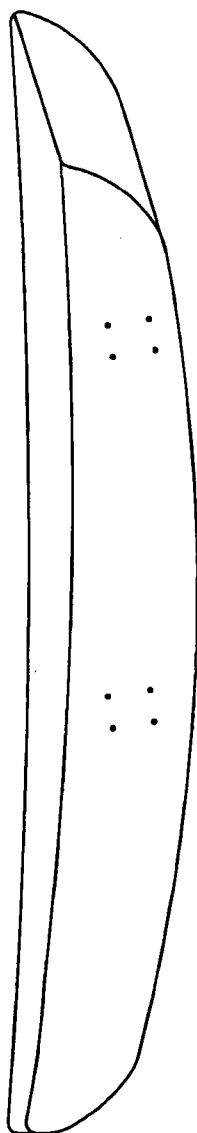
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22 [Signature]

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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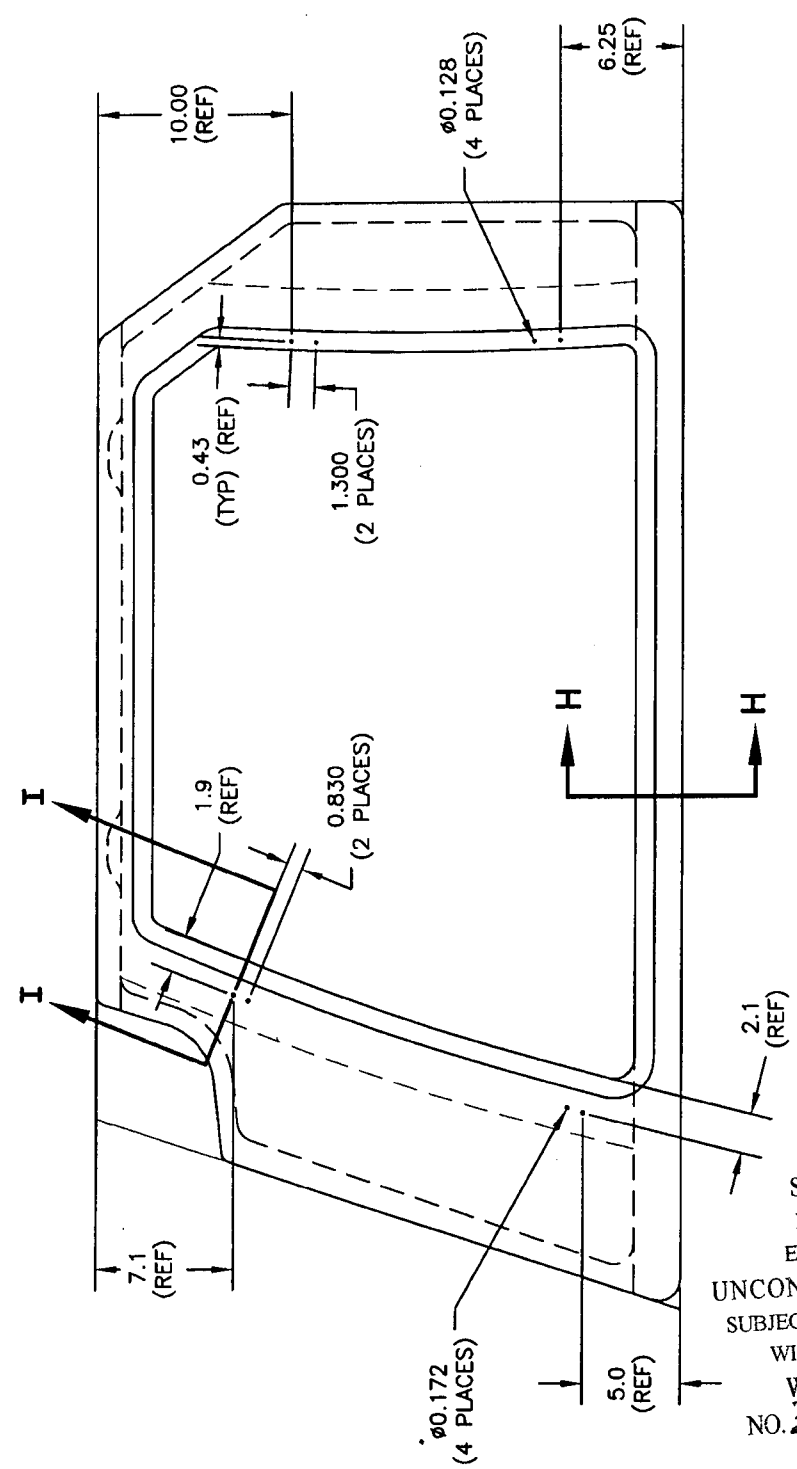
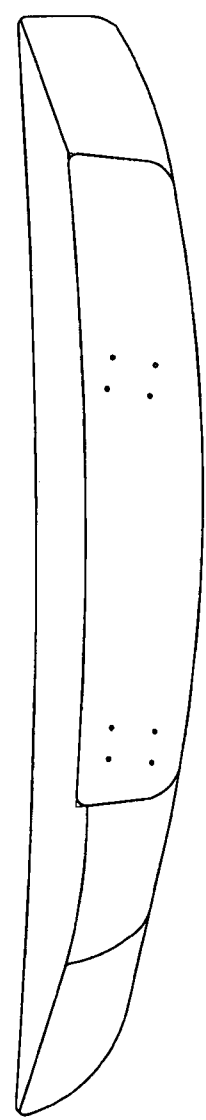
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
a.m. [Signature]

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

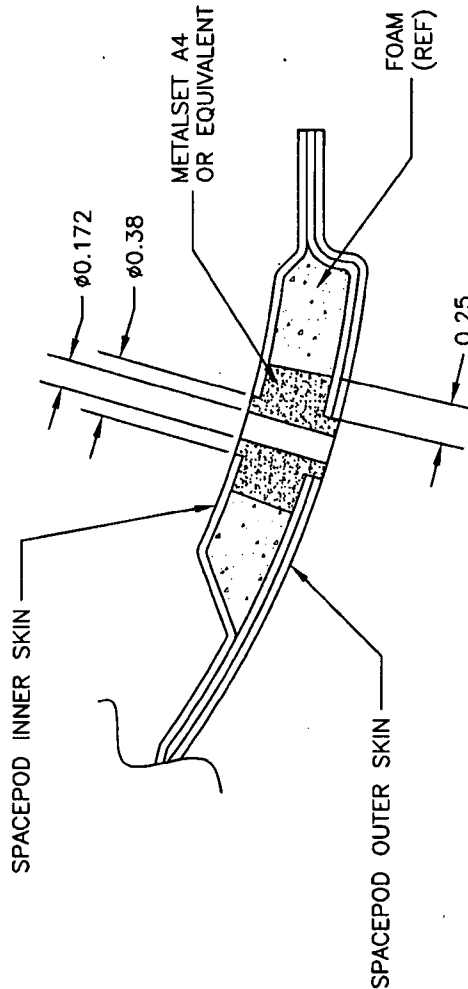
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06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Feuille de Procédé

Cliant : DART Dart Aerospace Ltd. Nom Dessin : SPACEPOD BODY
Numéro Job : 41312 Numéro Article : DKC134-0055
Numéro Soumission : 2587 Numéro Dessin : D3188
Numéro B.A. : Projet Numéro : DKC134
Cette fois : 2007-03-29 No. B.V. : Révision dessin : B
Prsht Rev. : NC Matériel : Fibre 7781 et Résine 411-350
Prem. fois : - - Type : Date Dûe : 2007-04-05 Qté: 1 Udm: UNITE
Job précédente : 41311


Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Dart Aerospace : D31882M



Process Sheet Rev.: 01 Modification générale selon les informations
de l'ingénierie

Produit additionnel

Numéro Job: 

# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006. Date: JUN 06 2007 Heure Début 8:00 Heure Fin 12:00 Sceau: 		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s) Stretchlon 200 poche à vide Vert		

Date: Jeudi, 2007-03-29 10:33:26

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire Qty.: 11.400 VERGE(s)/Unit Total : 11.400 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

LOT: 1-6121-2

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentaire Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot:

1-5964-1

9.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentaire Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50"

N° de Lot:

1-6113-3

10.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

MAY 22 2007

Date:

Heure Début:

8:00

Heure Fin:

12:00

Sceau:



12.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-5921-3

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6183-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot:

1-5502-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Date: Jeudi, 2007-03-29 10:33:26

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Date: Jeudi, 2007-03-29 10:33:26
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41312

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

Date: JUN 07 2007 Heure Début: 3:15 Heure Fin: 3:20 Sceau:

16.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: JUN 07 2007 Heure Début: 3:20 Heure Fin: 4:10 Sceau:

17.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 07 2007 Heure Début: 4:10 Heure Fin: 4:30 Sceau:

Curing Début: 3:20 Curing Fin: 8:00

18.0 AAC0457 ATC core-cell A500 plain 4'x8' 1" thick












Commentaire Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2

Date: Jeudi, 2007-03-29 10:33:26

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY	
Numéro Job: 41312		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs TAILLAGE DU MATÉRIEL Tailler le Foam Core 1" selon le plan de découpe et les gabarits Date: JUN 08 2007 Heure Début: 10:15 Heure Fin: 12:00 Sceau: 			
20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6183-1			
21.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s) Catalyst N° DDM-9 N° de Lot: 1-5921-3			
22.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART JUN 08 2007  Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.			
23.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s) Polybond B46F N° de Lot: 1-6066-1			
24.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART À l'aide du Polybond, coller ensemble les deux surfaces scellées Disposer des point sur les pièces pour conserver une pression de collage. Laisser sécher pour un minimum de deux heures. Quantité: 1 Date: JUN 08 2007 Sceau:  			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Quantité: Date: Sceau:

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: JUN 08 2007 Sceau:



Quantité: Date: Sceau:

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6/83-1

27.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-5921-3

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs
PRÉPARATION DU MATÉRIEL DART

JUN 11 2007



Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs
FABRICATION GÉNÉRALE PLASTIC COMMERCIAL

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.

Laisser sécher pendant 2 heures minimum.

Date: JUN 11 2007 Sceau:



S.V C.G. M.G

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

30.0 AAC0452 Polybond B46F

Commentaire Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)
Polybond B46F N° de Lot: 1-6066-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond.

Date: JUN 11 2007

Heure Début: 3:15

Heure Fin: 3:25

Sceau:



32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: JUN 11 2007

Heure Début: 3:25

Heure Fin: 3:45

Sceau:



33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE

Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: JUN 11 2007

Heure Début: 3:45

Heure Fin: 4:05

Sceau:



Curing Début: 3:25

Curing Fin: 4:35

Date: Jeudi, 2007-03-29 10:33:27

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polybond

Date: JUN 13 2007 Heure Début: 8:00 Heure Fin: 11:00 Sceau:



37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

JUN 13 2007



Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6183-1

39.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-5921-3

40.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

JUN 13 2007



Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core

Laisser sécher pendant minimum deux heures.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

41.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)
Catalyst N° DDM-9

N° de Lot:

1-5921-3

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6183-1

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIELFaire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date:

JUN 13 2007

Heure Début:

12:30

Heure Fin:

12:40

Sceau:



44.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date:

JUN 13 2007

Heure Début:

12:40

Heure Fin:

1:30

Sceau:



45.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: Jeudi, 2007-03-29 10:33:27

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: JUN 13 2007 Heure Début: 1:30 Heure Fin: 1:50 Sceau:

Curing Début: 12:40 Curing Fin: 8:00



46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: JUN 14 2007 Heure Début: 10:15 Heure Fin: 11:00 Sceau:



47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, percer les 8 dégagement de $\varnothing .745"$ pour les spacers N° D2213 (ne pas percer la peau extérieur de la pièce)

Date: JUN 14 2007 Heure Début: 12:30 Heure Fin: 1:00 Sceau:



48.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6183-1

50.0

AAC0673

Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

Date: Jeudi, 2007-03-29 10:33:27

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description:

51.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 18 2007 Heure Début: 9:00 Heure Fin: 9:05 Sceau:

52.0

AAC0448

Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total: 8 UNITE(s)

Spacer N° D2213

N° de Lot:

1-5949-1

53.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

ASSEMBLAGE GÉNÉRALE DES PIÉCES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.

Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous

Appliquer un pression sur les pièces de 9 ox à l'aide d'un bloc de bois et de pinces autobloquantes

Laisser sécher pendant 4 heures minimum.

Date: JUN 18 2007 Heure Début: 9:05 Heure Fin: 10:00 Sceau:

Curing Début: 9:00 Curing Fin: 1:00

54.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total: 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-5921-3

55.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6183-1

Date: Jeudi, 2007-03-29 10:33:27

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

56.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 15 2007

Heure Début: 10:15

Heure Fin: 10:20

Sceau:



57.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièce. Selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: JUN 15 2007

Heure Début: 10:20

Heure Fin: 11:20

Sceau:



Curing Début: 10:20

Curing Fin: 3:15

58.0

FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Repercer les 8 trous des spacers afin de les déboucher

18-6-07



Sabler les surfaces de la pièce pour aider à l'adhésion du primer et enlever les imperfections.

8-20-6-07



59.0

AAC0671

Dupont Primer N° 1104S

Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S

N° de Lot: 1-6065-2

60.0

AAC0670

Dupont Activation N° 7975S

Commentaire Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activation N° 7975S

N° de Lot: 1-6065-1

Date: Jeudi, 2007-03-29 10:33:27

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41312

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

61.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: 1-6149-2

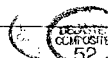
62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Nettoyages ATy 1 20-06-07

JUN 20 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

63.0 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer une couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer

Laisser sécher pendant 3 heures minimum

Date: JUN 20 2007

Heure Début: _____ Heure Fin: _____ Sceau: _____



64.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.020 UNITE(s)/Unit Total: 0.020 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

65.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

66.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide du Sikkens

Faire un léger sablage (Grit 220) de toute les surfaces.

Date: JUN 21 2007

Heure Début: 7:30 Heure Fin: 4:30 Sceau: _____



Date: Jeudi, 2007-03-29 10:33:27
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41312

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

67.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-60652

68.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-6065-1

69.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-6149-2

70.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Nettoyages 22-06-07

JUN 22 2007

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

71.0 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
APPLICATION DE PRIMER

Appliquer deux couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les couches.

Laisser sécher pendant 3 heures minimum

Date: JUN 22 2007

Heure Début: _____ Heure Fin: _____ Sceau: 16

72.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 24/06/07 Sceau: 11

Initiales: M.S.

73.0 EMBALLAGE 3 EMBALLAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
EMBALLAGE PIÈCE DART

Faire l'emballage dans le contenant approprié.

Date: Wednesday, 3/7/2007 2:26:19 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 31048C	
Estimate Number : 11099	
P.O. Number : <i>N/A</i>	Part Number : D31862
This Issue : 3/7/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3186
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : 3/7/2007 Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 30625B	Material : <i>N/A</i>
Written By : _____	Due Date : 3/30/2007 Qty: 1 Um: Each
Checked & Approved By : <i>07.03.07</i>	
Comment : Est Rev:A New Issue 05-11-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	31048C01	SPACEPOD DOOR RH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR RH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

*w/o 30087*

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-2 detail)

ml 07/07/17

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/17 (XL)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA**ml 07/07/17*

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

07/07/26

Job Completion

*U 07.07.26*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

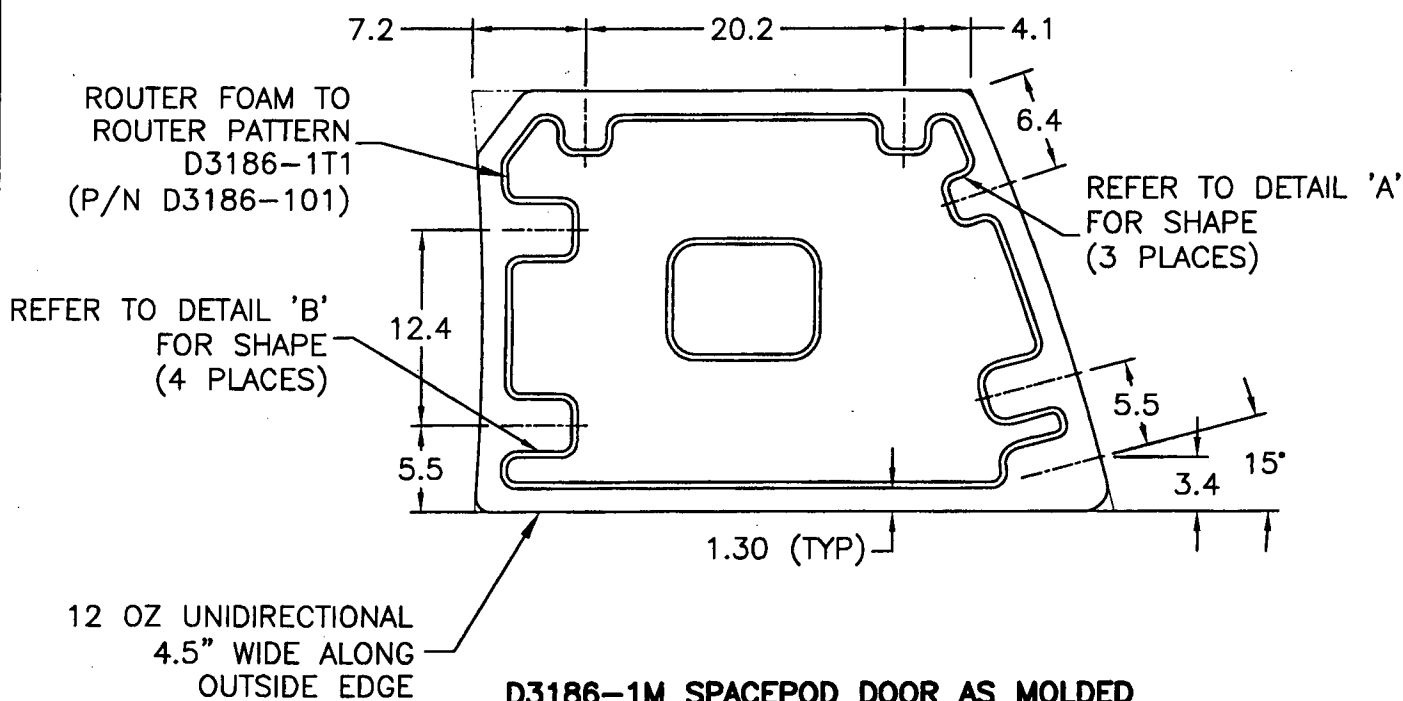
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06.12.22

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31048C

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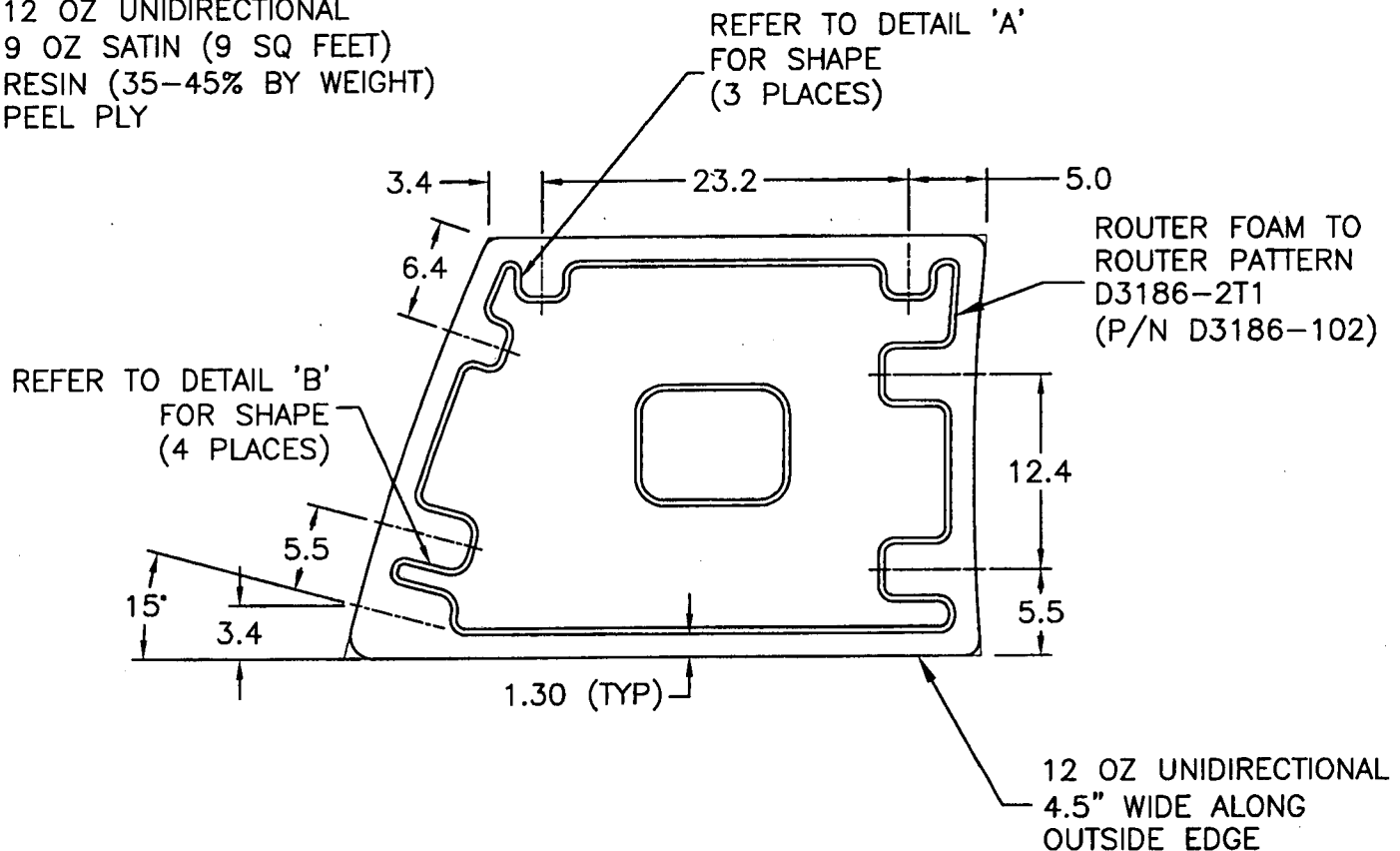
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DART

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
06.12.13MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

**D3186-2M SPACEPOD DOOR AS MOLDED**NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 31048C

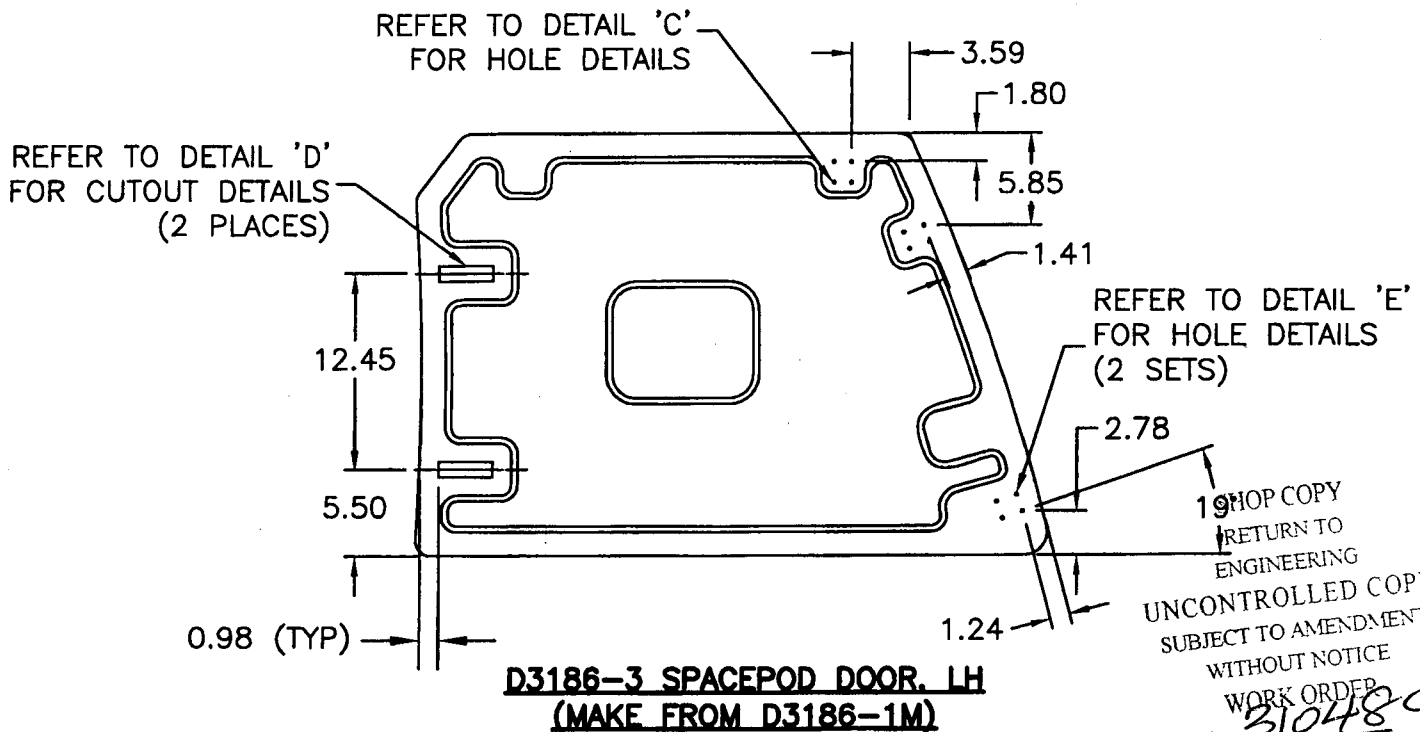
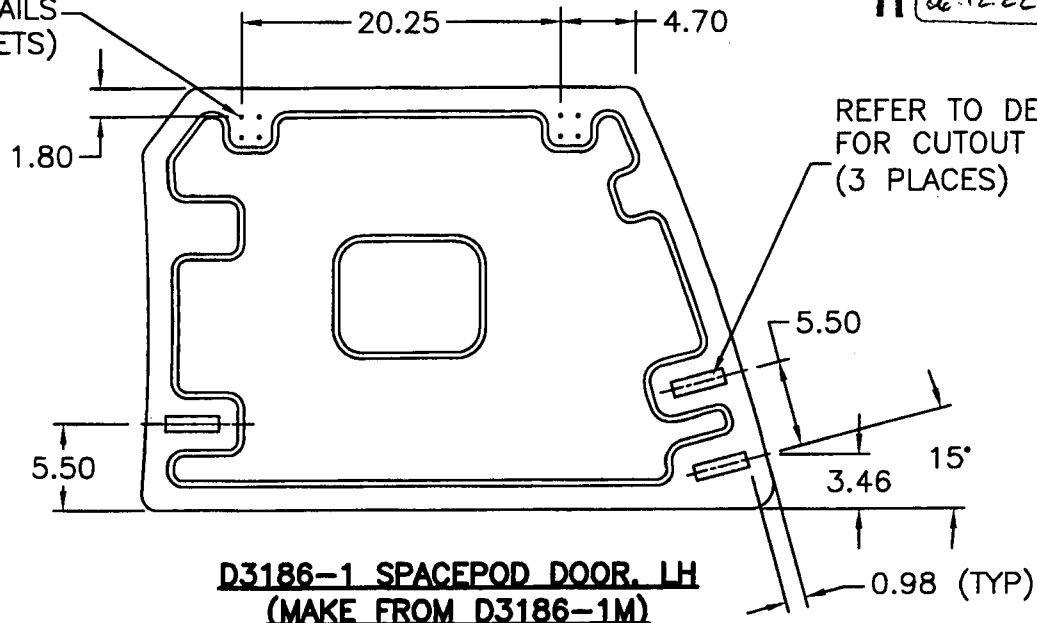
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. C SHEET 3 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
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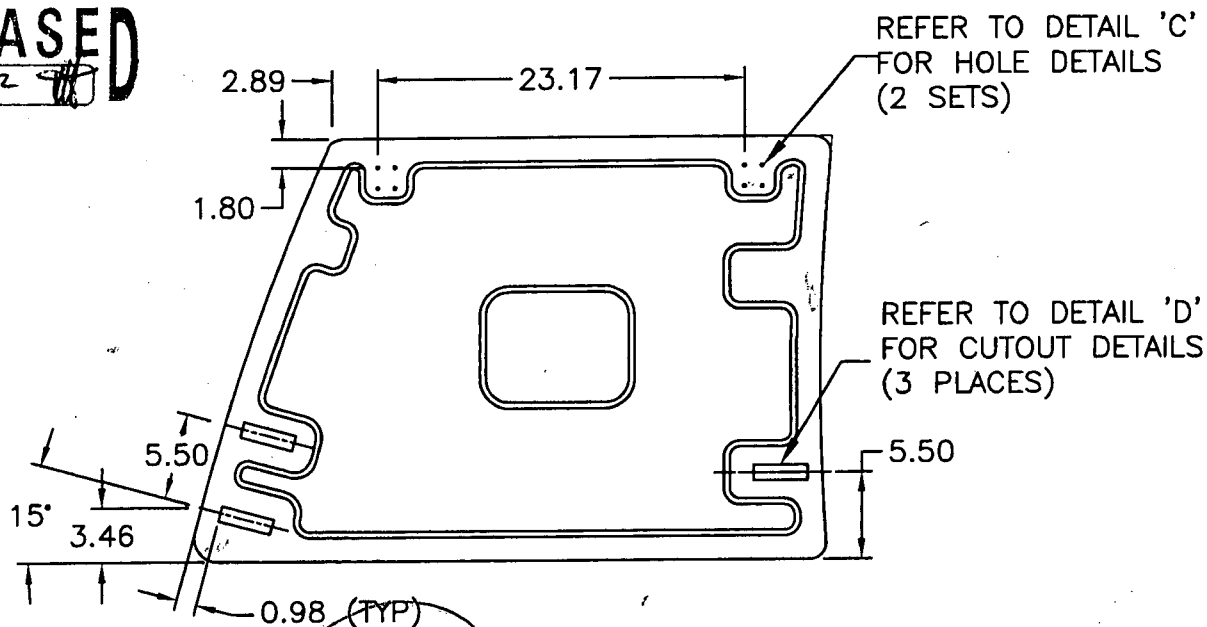
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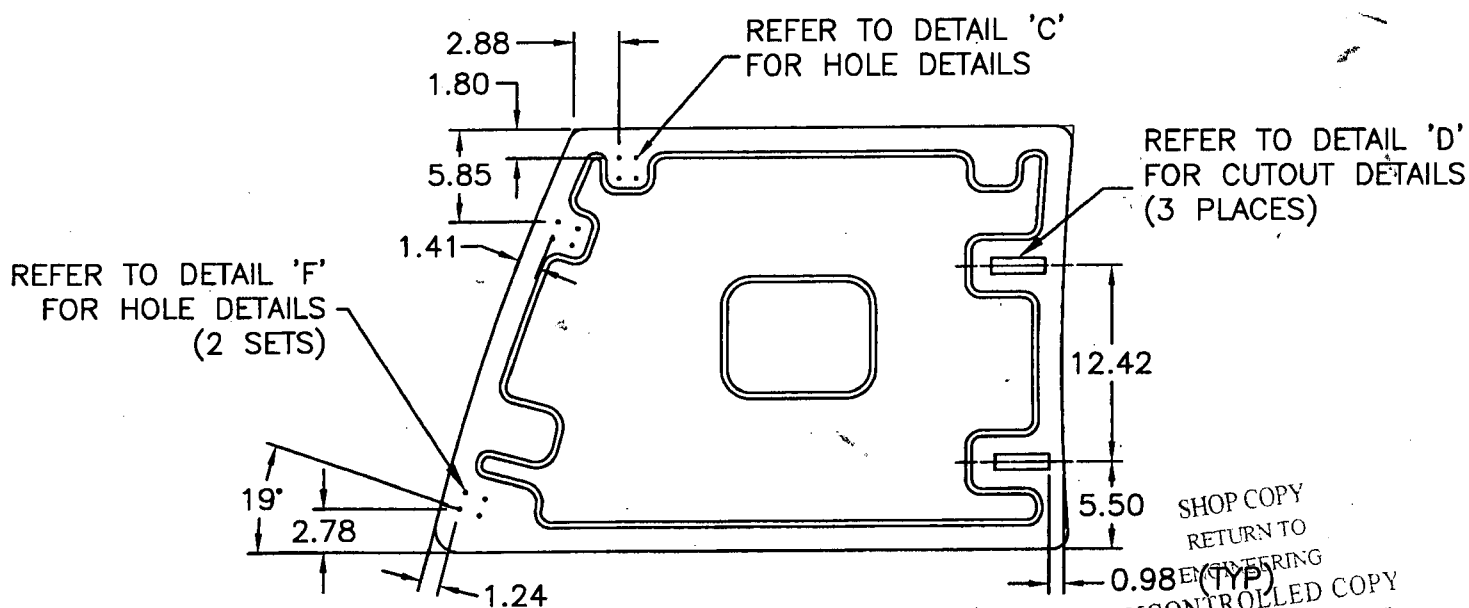


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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 4 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

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06.12.22 [Signature]



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

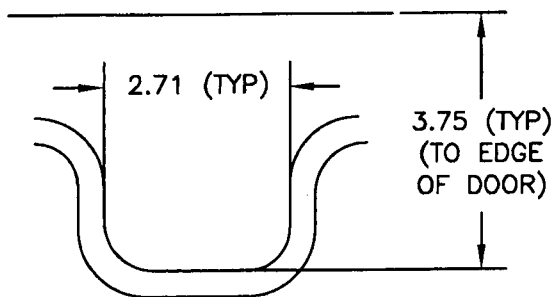
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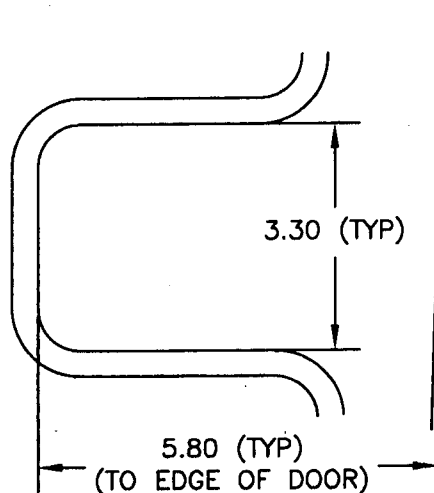
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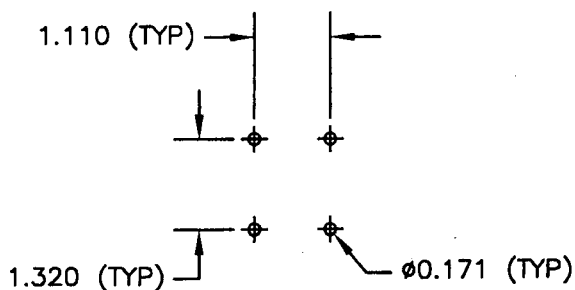
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 5 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



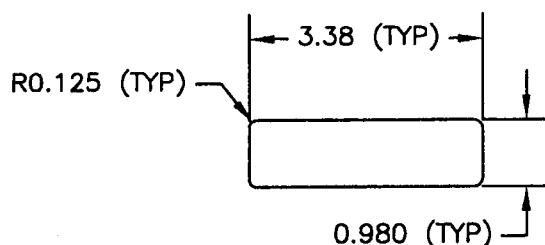
DETAIL A



DETAIL B

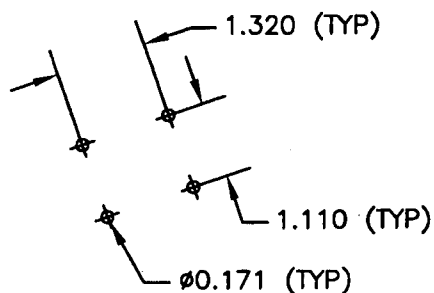


DETAIL C

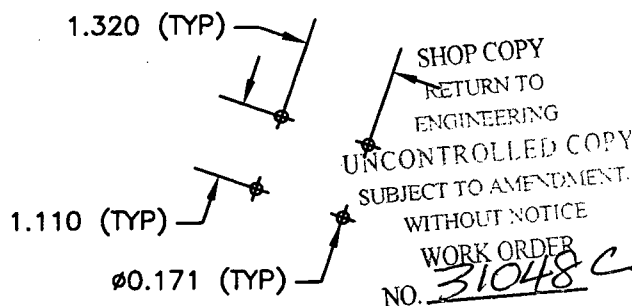


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Thursday, 12/21/2006 12:55:17 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 30087
 Estimate Number : 12599
 P.O. Number : *N/A*
 This Issue : 12/21/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : PURCHASED PARTS
 Previous Run : 30086
 Drawing Name : SPACEPOD DOOR RH
 Part Number : D31862M
 Drawing Number : D3186 REV *BC* *LE 07.01.18*
 Project Number : N/A
 Drawing Revision : *BC* *LE 07.01.18*
 Material : *N/A*
 Due Date : 2/28/2007 Qty: 1 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: A New Issue 06-12-04 ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *2771*

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

C Log 110102
①

2.0 D31862P Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

[Signature]
07/07/03 *①*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186. Visual inspection. Check for void spot and pins.

ml 07/07/17

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

ml 07/07/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 12/21/2006 12:55:17 PM
User: Kimi Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 30087

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D31862M

Job Completion



u 07.07.26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

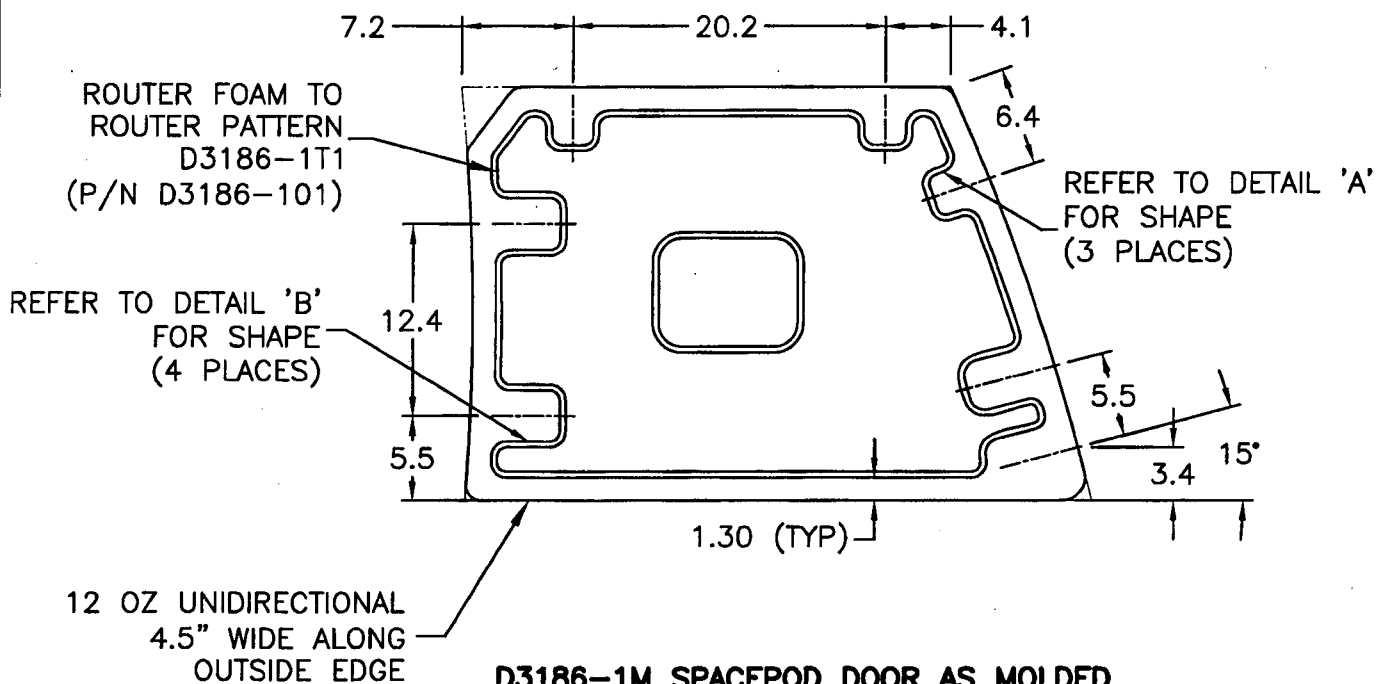
NOTE: Date & initial all entries



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CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

RELEASED
06.12.22

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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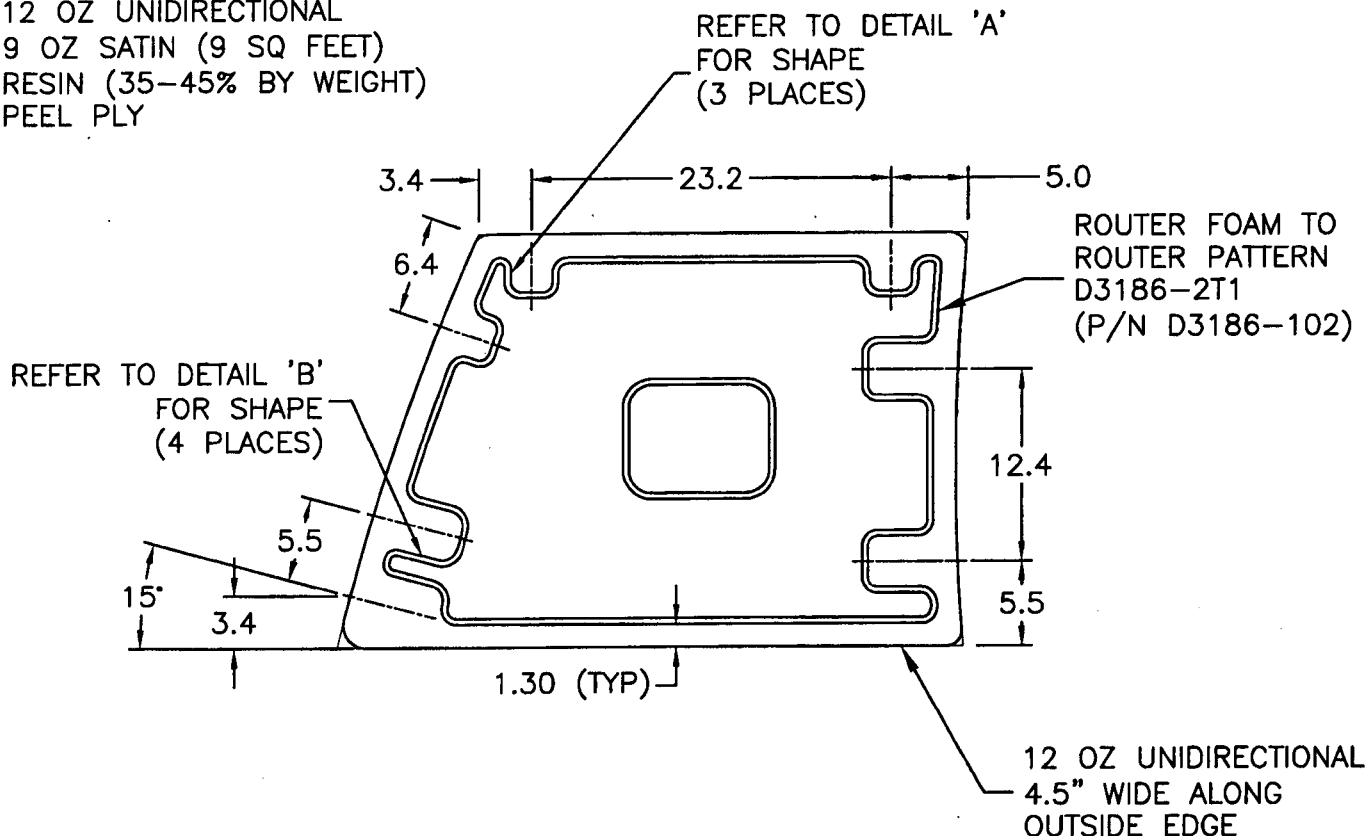
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CHECKED PH	APPROVED #	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
06.12.13**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
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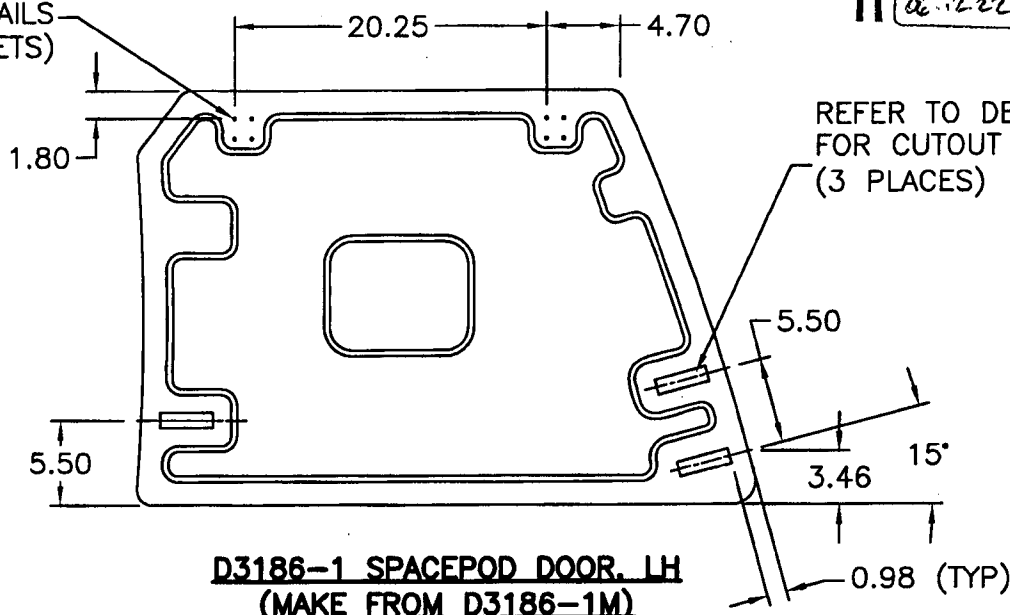
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DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

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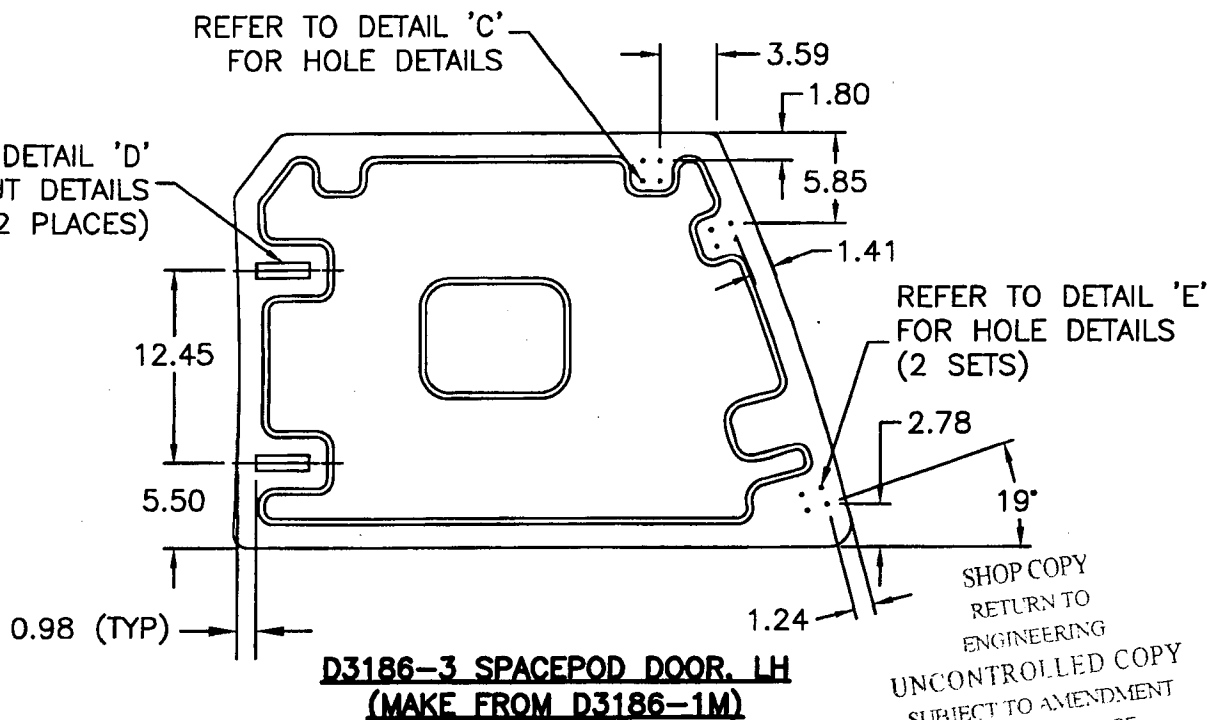
REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)

REFER TO DETAIL 'C'
FOR HOLE DETAILS

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)



REFER TO DETAIL 'E'
FOR HOLE DETAILS
(2 SETS)

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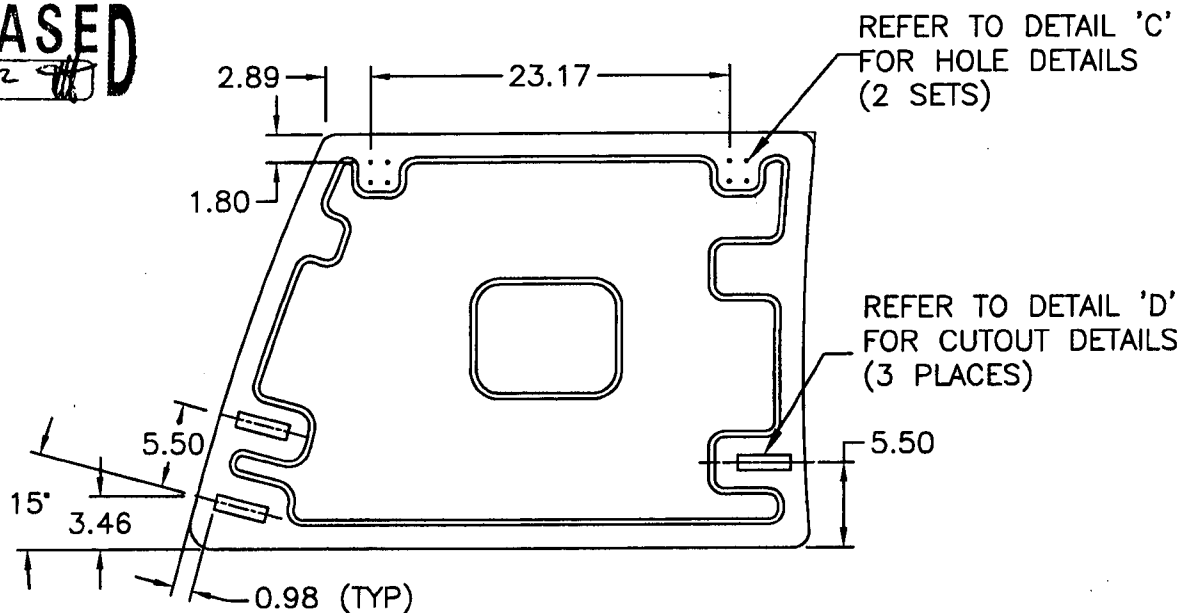
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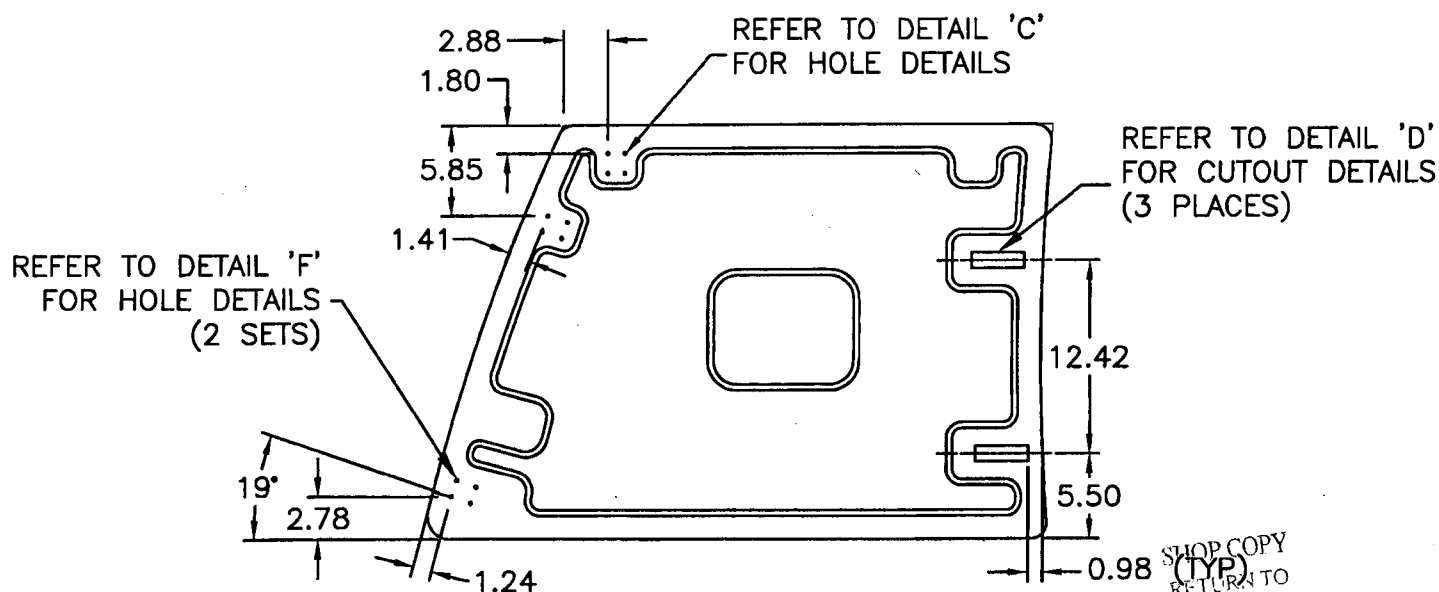


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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

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06.12.22 [Signature]



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

NOTES:

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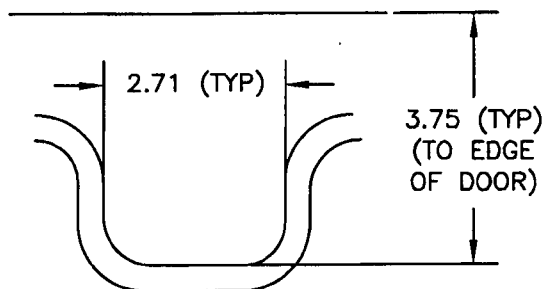
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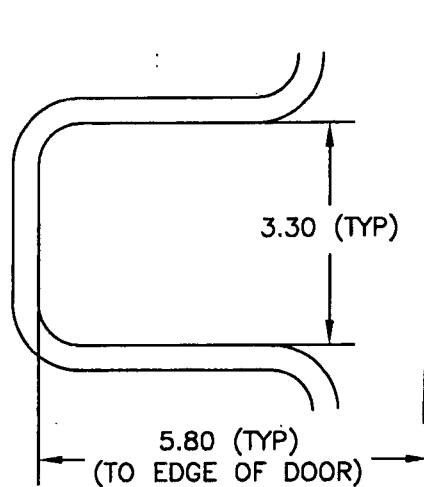
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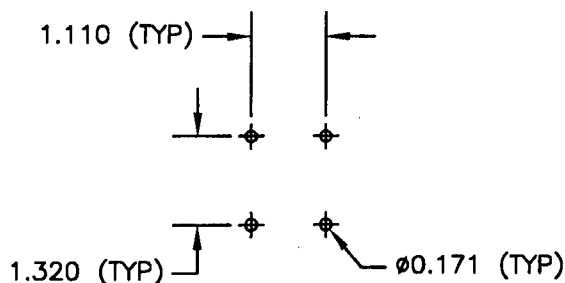
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



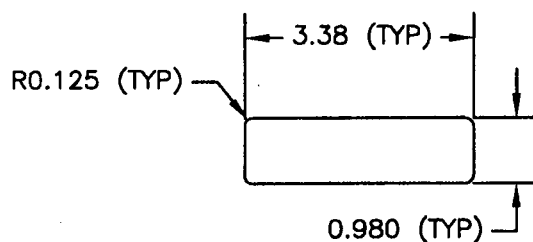
DETAIL A



DETAIL B

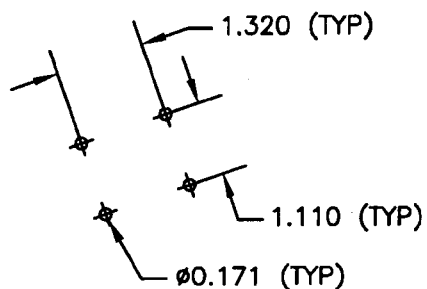


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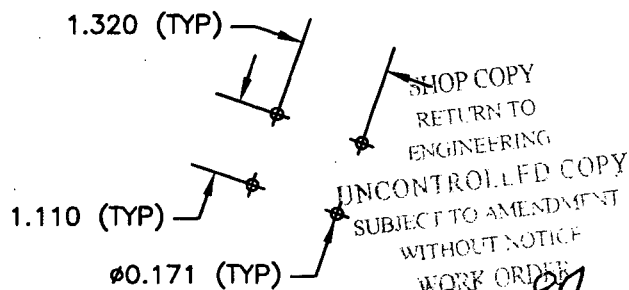


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12035
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/06/2007	22/12/2006	5093	C. Lavoie		PO00002771		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30087 Dwg. Rév.: D Job: 41784 U de M : Each			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30092 Dwg. Rév.: D Job: 41312 U de M : Each			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30077 Dwg. Rév.: D Job: 41783 U de M : Each			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30082 Dwg. Rév.: D Job: 41303 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

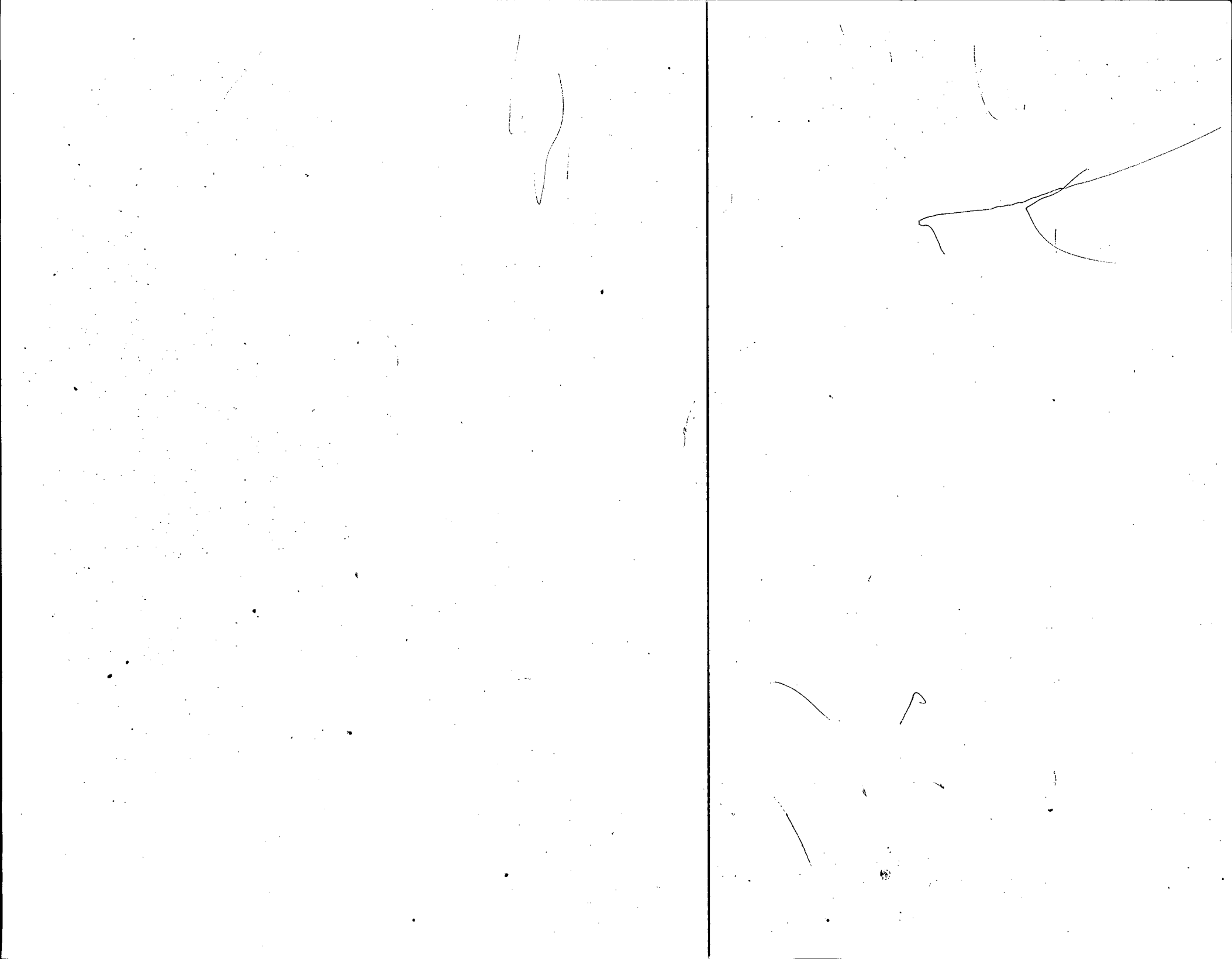
☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Michel St-Hilaire
Quality department

AQ-357





Date: Lundi, 2007-06-11 08:18:13
 Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : SPACEPOD DOOR	
Numéro Job : 41784		Numéro Article : DKC134-0054	
Numéro Soumission : 2586		Numéro Dessin : D3186	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2007-06-11	No. B.V. :	Révision dessin : C	
Prsht Rev. : NC		Matériel : Fibre 7781 et Résine 411-350	
Prem. fois : -	Type :	Date Dûe : 2007-06-18	Qté: 1 Udm. UNITE
Job précédente : 41554			

Écrit par : _____
 Vérifié & Approuvé par : _____
 Commentaires : N° de pièce Dart Aerospace : D31862M


 Process Sheet Rev.: 02 Ajouter une séquence d'emballage et une
 séquence d'inspection du positionnement de foam Core

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0303 Frekote 44NC

 Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
 Frekote 44NC

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
 PRÉPARATION DU MOULE

 Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon
 le QSI-006.

Date: JUN 05 2007 Heure Début: 12:30 Heure Fin: 4:30 Sceau:



3.0 AC0409 Tissu à délaminer Release ply B

 Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
 Tissu à délaminer Release ply B

4.0 AC0407 Wrightlon 5200 Bleu P3

 Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
 Wrightlon 5200 Bleu P3

5.0 AC0408 Feutre de drainage N° Airweave N 10

 Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
 Feutre de drainage N° Airweave N 10

6.0 AC0752 Stretchlon 200 poche à vide Vert.

 Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
 Stretchlon 200 poche à vide Vert

Date: Lundi, 2007-06-11 08:18:14

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41784

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire Qty.: 4.500 VERGE(s)/Unit Total: 4.500 VERGE(s)
9.7 oz Weave #FG-778150-125Y Volan Finish # LOT: 1-6178-2

8.0	AAC0443	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)
Fiberglass 12 oz Unidirectional N° de Lot: 1-5964-1

9.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
-----	--------	-----------------------------------

Commentaire Qty.: 2.2500 RL(s)/Unit Total: 2.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le côté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: JUN 06 2007

Heure Début: 12:30

Heure Fin: 2:00

Sceau:



11.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 1-5921-3

12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-6183-1

13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 06 2007

Heure Début: 2:30

Heure Fin: 2:35

Sceau:



Date: Lundi, 2007-06-11 08:18:14
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41784

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

14.0	LAMINAGE.	LAMINAGE PIÈCE DART
------	-----------	---------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: JUN 06 2007

Heure Début: 2:35

Heure Fin: 2:50

Sceau:



15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 06 2007

Heure Début: 2:50

Heure Fin: 3:00

Sceau:



Curing Début: 2:35

Curing Fin: 8:00

16.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0120 PINTE(s)/Unit Total: 0.0120 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-5921-3

17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total: 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6183-1

Date: Lundi, 2007-06-11 08:18:14

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41784

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heure.

Date: JUN 05 2007

Heure Début: 10:15

Heure Fin: 10:30

Sceau:



19.0	AAC0452	Polybond B46F
------	---------	---------------

Commentaire Qty.: 0.082 KIT(s)/Unit Total: 0.082 KIT(s)
Polybond B46F N° de Lot: 1-6060-1

20.0	DKC134-0057	Foam Core N° D3186-102 (Porte D3186-2)
------	-------------	--

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Foam Core N° D3186-102 (Porte D3186-2)

N° de Job:

1-5826-1

21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
------	--------------	--------------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIÉCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Faire l'inspection du positionnement par le département de la qualité

Date: _____ Sceau: _____ Initiales: _____

N/A
18-06-07

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: JUN 07 2007

Heure Début: 11:30

Heure Fin: 11:50

Sceau:



Date: Lundi, 2007-06-11 08:18:14
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41784

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond

Date: JUN 07 2007

Heure Début: 11:50 Heure Fin: 12:00 Sceau: 32



Curing Début: 11:30 Curing Fin: 12:45

23.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-5921-3

24.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6183-1

25.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 08 2007

Heure Début: 8:55 Heure Fin: 9:00 Sceau: 65



Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41784

Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description :

26.0 LAMINAGE LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: JUN 08 2007

Heure Début: 9:00

Heure Fin: 9:40

Sceau:



27.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 08 2007

Heure Début: 9:40

Heure Fin: 10:00

Sceau:



Curing Début: 9:00

Curing Fin: 2:00

28.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abîmer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le le moule afin d'éliminer le fini lisse de celui-ci.

Date: JUN 08 2007

Heure Début: 3:50

Heure Fin: 3:55

Sceau:



Date: Lundi, 2007-06-11 08:18:14

Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41784

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
------	-----------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: JUN 08 2007 Heure Début: 3:55 Heure Fin: 4:25 Sceau:



30.0	AAC0671	Dupont Primer N° 1104S
------	---------	------------------------

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S

N° de Lot: 1-6149-1

31.0	AAC0670	Dupont Activator N° 7975S
------	---------	---------------------------

Commentaire Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S

N° de Lot: 1-6065-1

32.0	AAC0672	Dupont Reducer N° 12375S
------	---------	--------------------------

Commentaire Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: 1-5092-2

33.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Nettoyages Qty 1 11-06-07

JUN 11 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

34.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Appliquer une première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.
Application primer

Laisser sécher pendant 3 heures.

Date: • Lundi, 2007-06-11 08:18:14

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41784

Numéro Article: DKC134-0054

Numéro Job:



Séq.: Machine ou Opération: Description:

Date: JUN 11 2007 Heure Début: _____ Heure Fin: _____ Sceau:

35.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

37.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

38.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: 12-6-07 Heure Début: 1:00 Heure Fin: 3:30 Sceau:

39.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-6149-1

1-6065-2

40.0 AAC0670 Dupont Activator N° 7975S

Commentaire Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-6065-1

41.0 AAC0672 Dupont Reducer N° 12375S

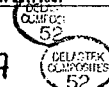
Commentaire Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-6065-2

42.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

MASQUAGE 12-06-07
Nettoyage 13-06-07



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

MASQUAGE + Nettoyage 14-06-07



JUN 13 2007



JUN 14 2007



Date: Lundi, 2007-06-11 08:18:14

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41784

Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

43.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

APPLICATION DE PRIMER

JUN 14 2007

Appliquer une deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.

Application de primer.

JUN 13 2007

Date: _____ Heure Début: _____ Heure Fin: _____ Sceau: _____



44.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

INSPECTION PIÈCE DART

Inspection des pièces par le département de la qualité

Quantité: 1 Date: 18/06/07 Sceau: _____



Quantité: _____ Date: _____ Sceau: _____

45.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 18/6/07 Sceau: _____



Quantité: _____ Date: _____ Sceau: _____

Date: Wednesday, 3/7/2007 2:26:19 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY RH
Job Number	: 31048B		
Estimate Number	: 12596		
P.O. Number	:	Part Number	: D31882M
This Issue	: 3/7/2007 S.O. No. :	Drawing Number	: D3188
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 30625A01	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>3/07.03.07</u>		
Comment	: Est Rev: A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

W/O 30092

8 D2213 Spacer Batch: _____

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING
 Issue P/O: _____
 Description: D3188-2M BODY
 SHIP: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 2:26:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 31048B

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ce J. 07. 26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
JB	CE	DRAWING NO.	REV. C
CHECKED PH	APPROVED AK	D3188	SHEET 1 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY	SCALE NTS	
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	

GENERAL NOTES:

- REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

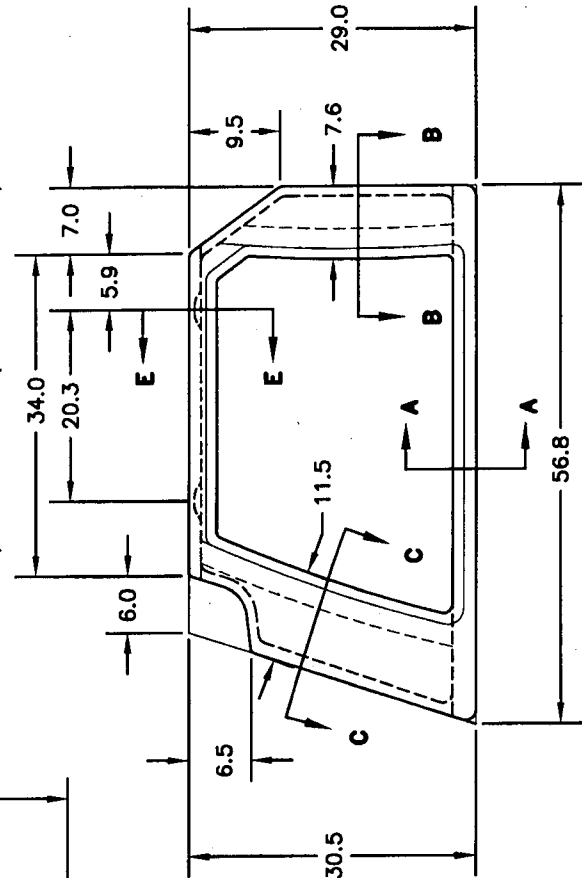
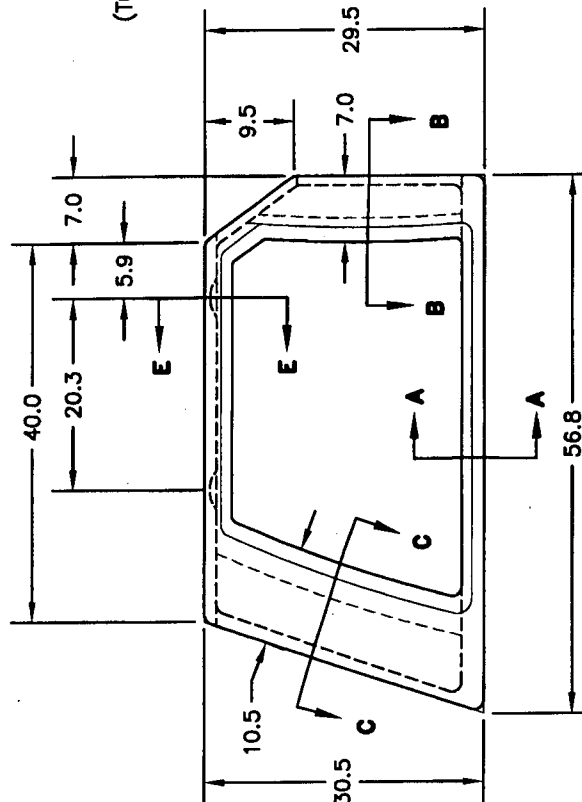
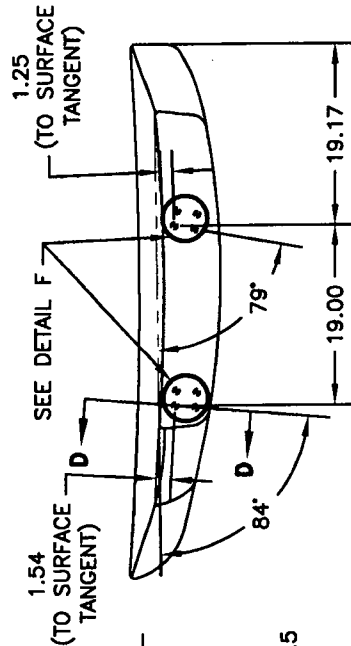
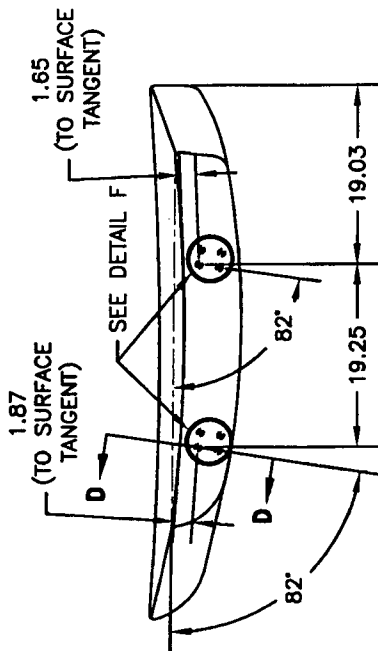
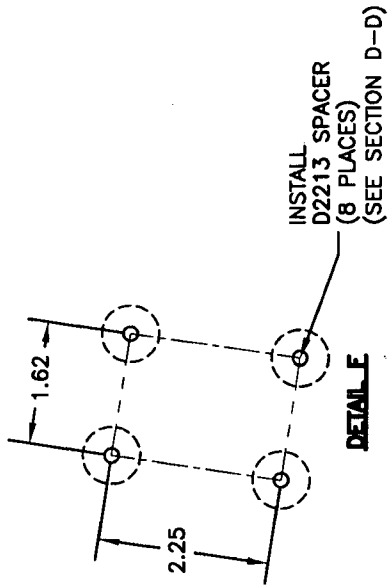
- APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 310485
WORK ORDER

RELEASED
06.12.22



DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 2 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. **31048B**
RELEASED
06-12-22

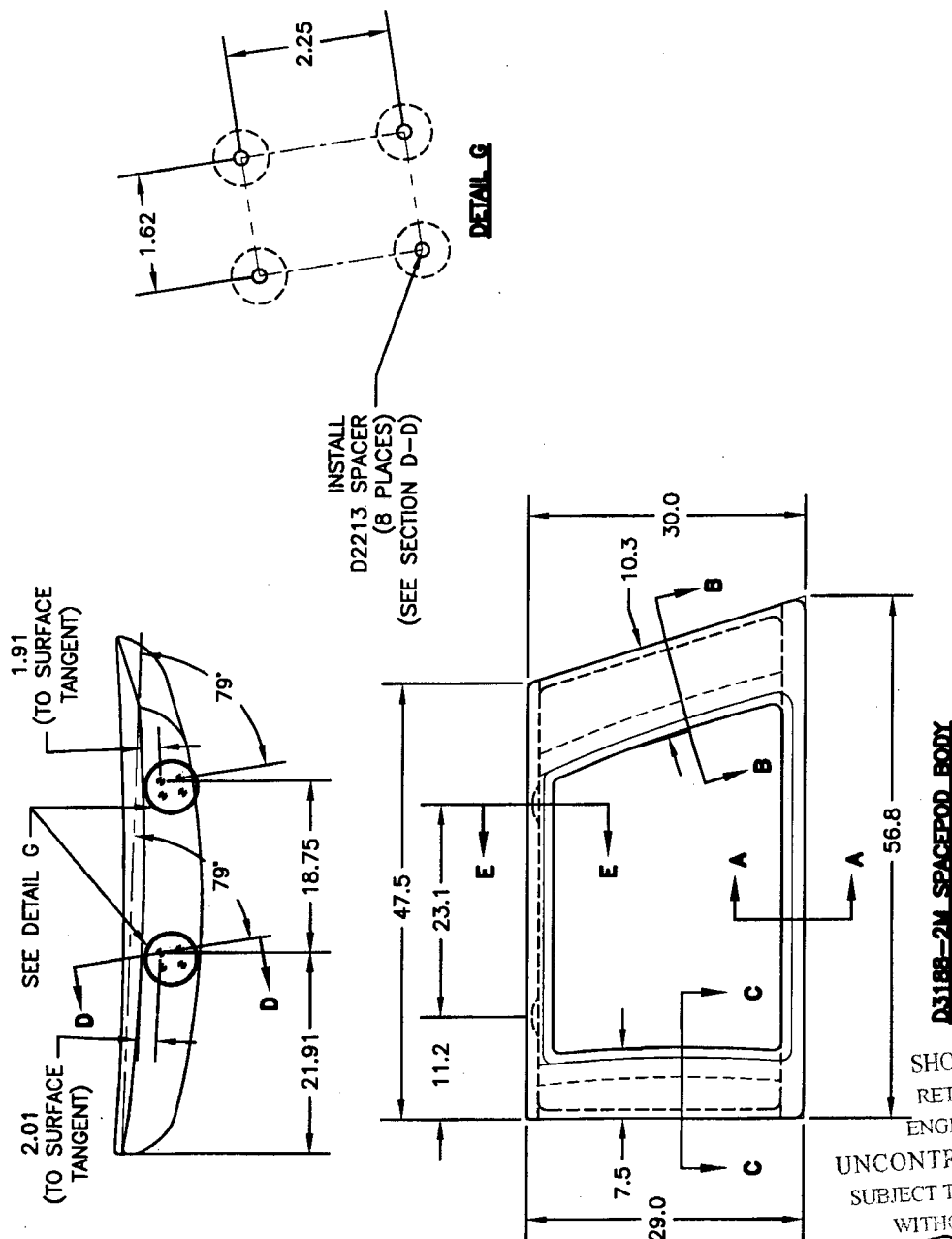
NOTE: SEE SHEET #4 FOR SECTION VIEWS

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DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3188	REV. C SHEET 3 OF 11
DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



RELEASED
06.12.22

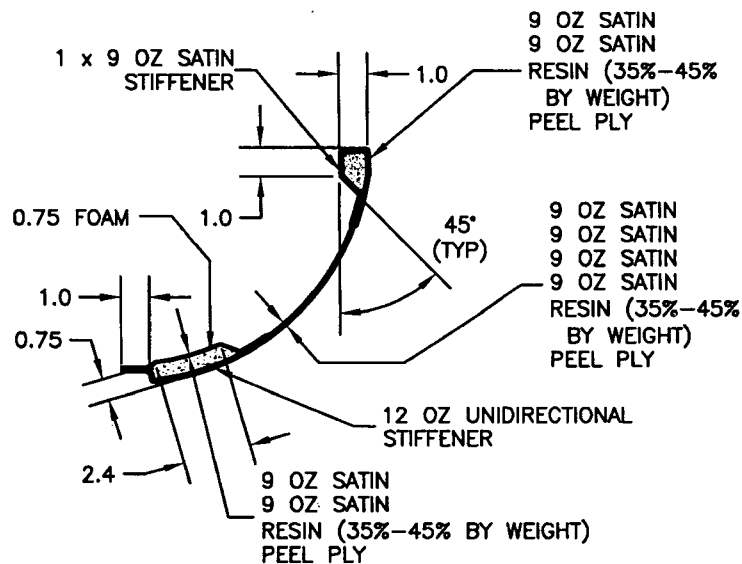
NOTE: SEE SHEET #4 FOR SECTION VIEWS

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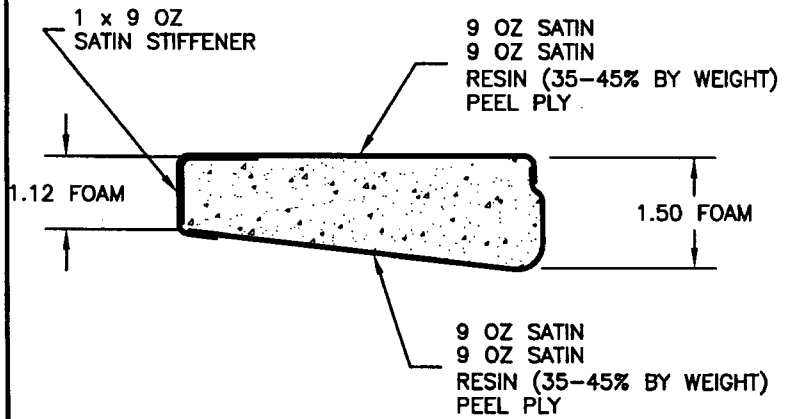
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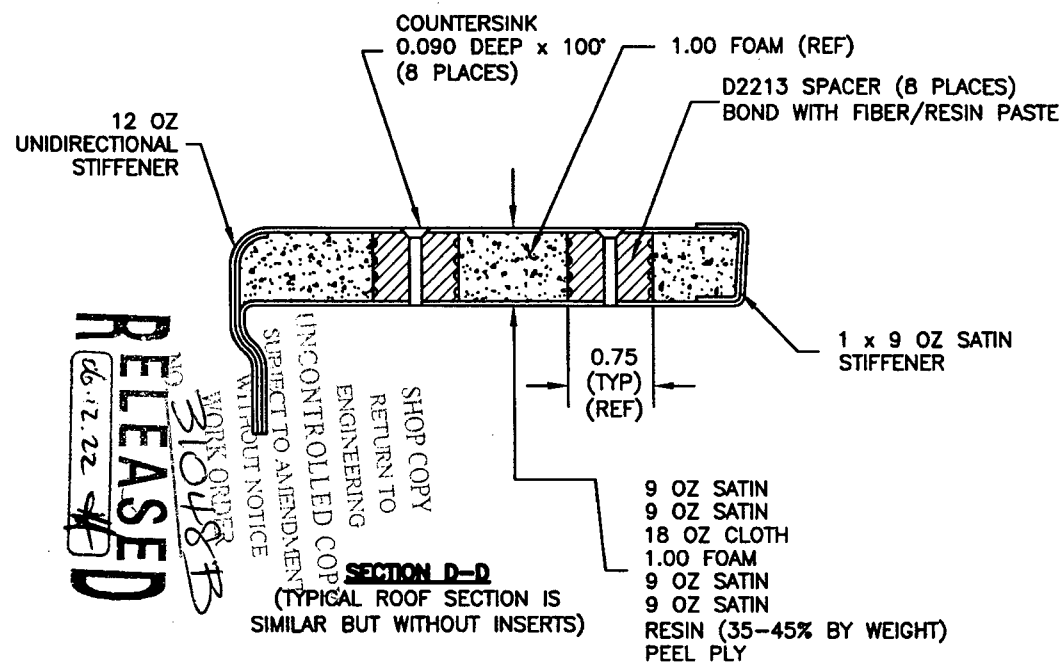
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DATE	06.12.13	DRAWING NO.	D3188	REV. C
		TITLE	SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS



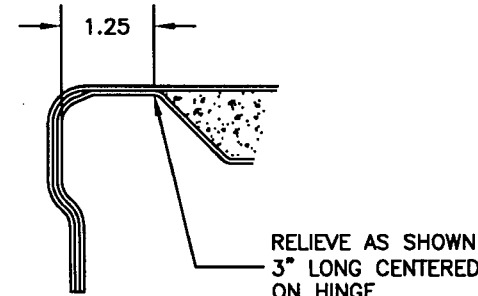
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



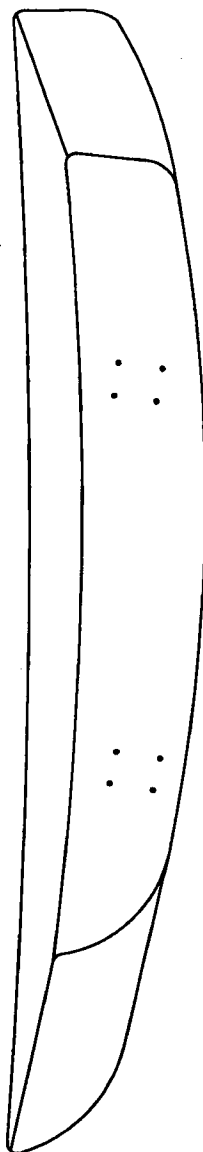
SECTION E-E
(2 PLACES PER POD)

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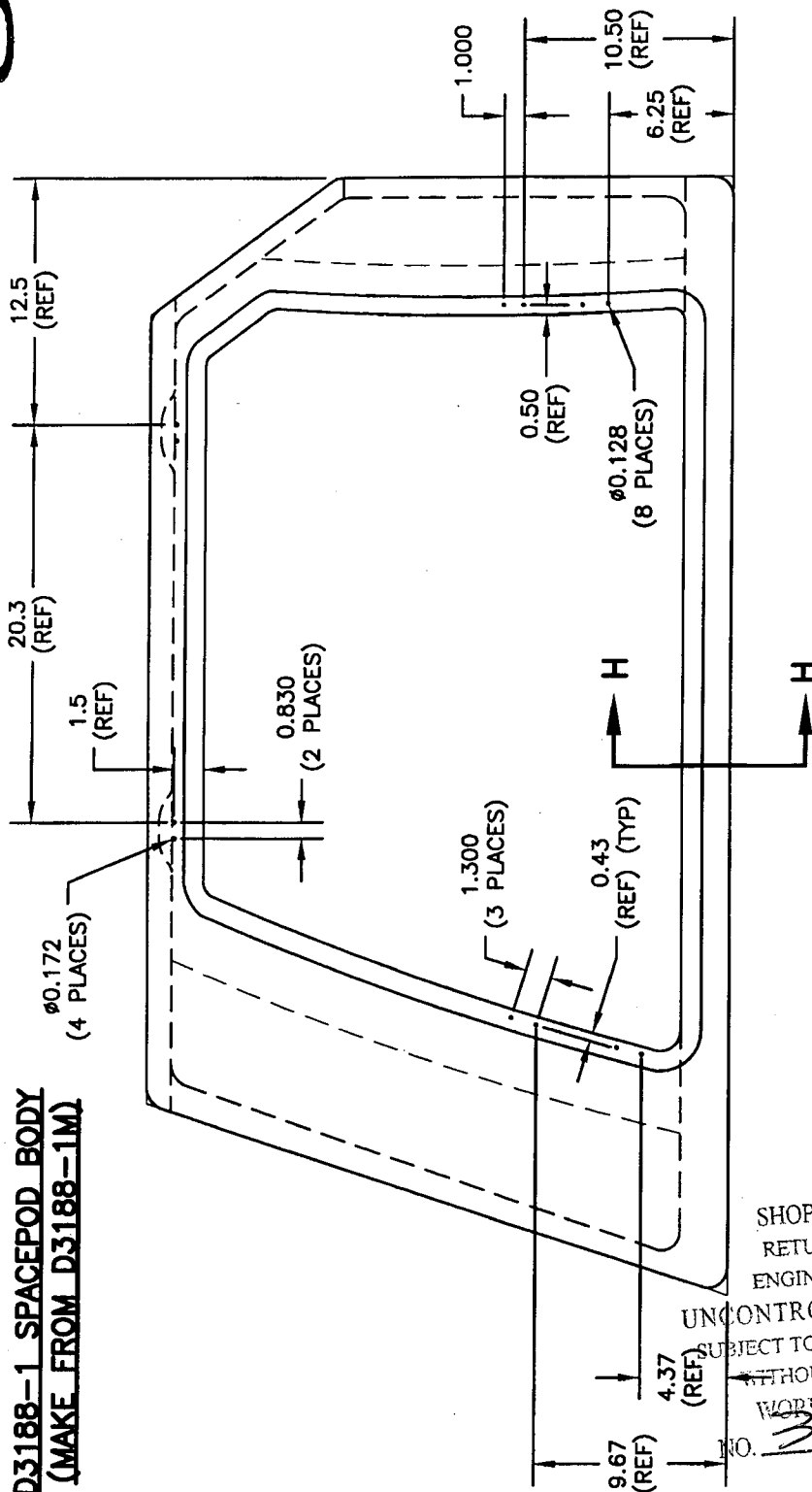


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**



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NOTES:

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- 2) SEE SHEET #11 FOR SECTION VIEW

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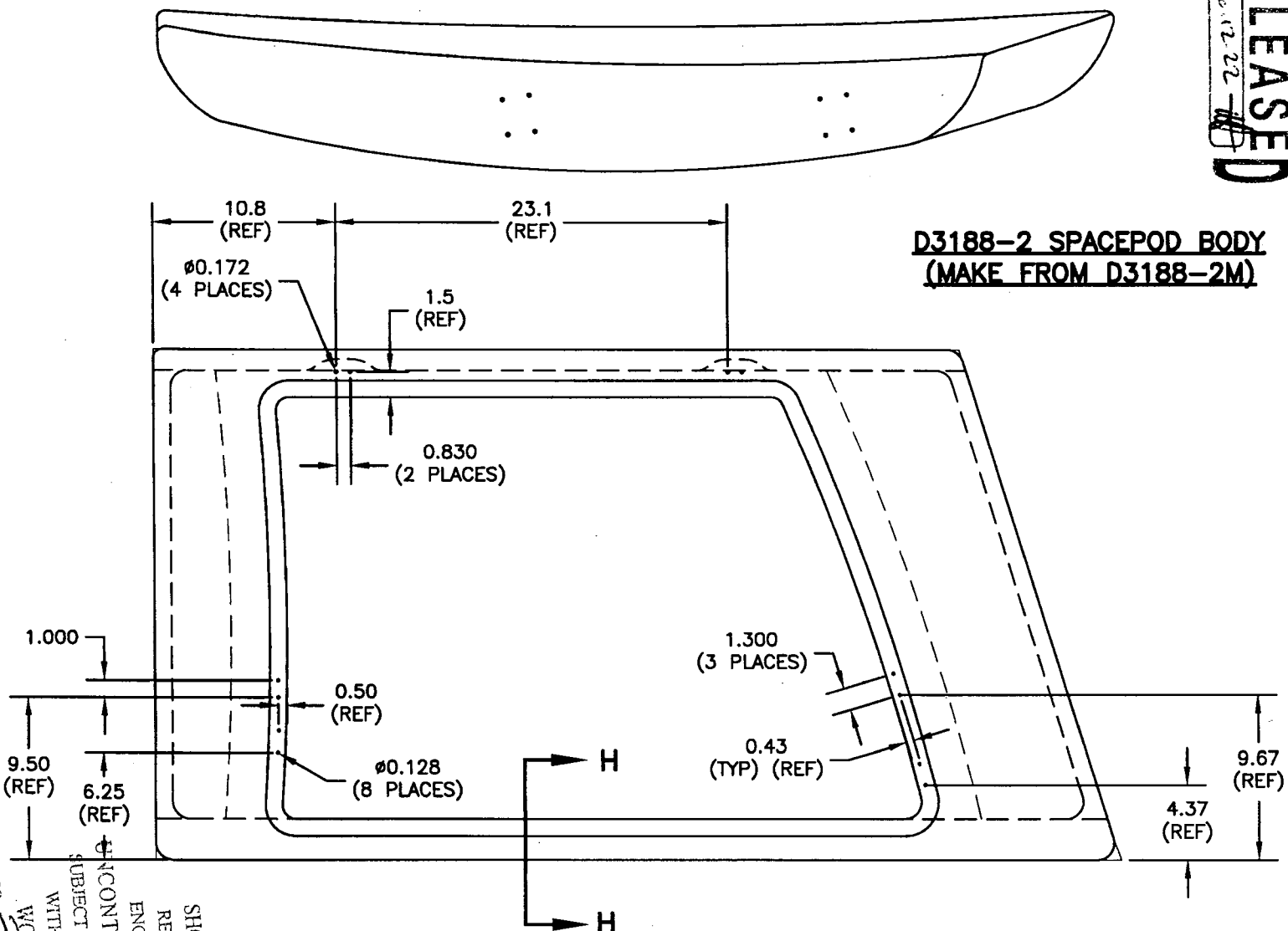
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DATE	06.12.13	TITLE	SPACEPOD BODY		SCALE
					NTS

D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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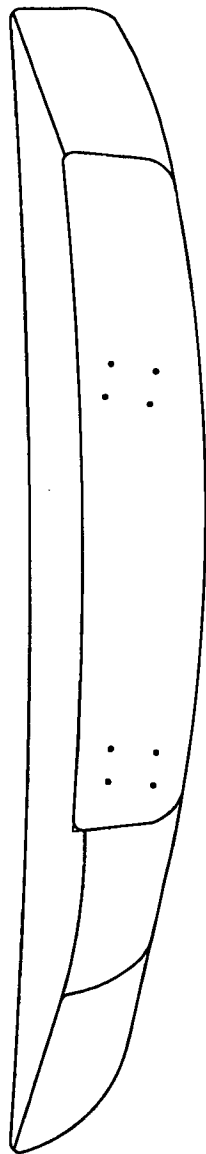
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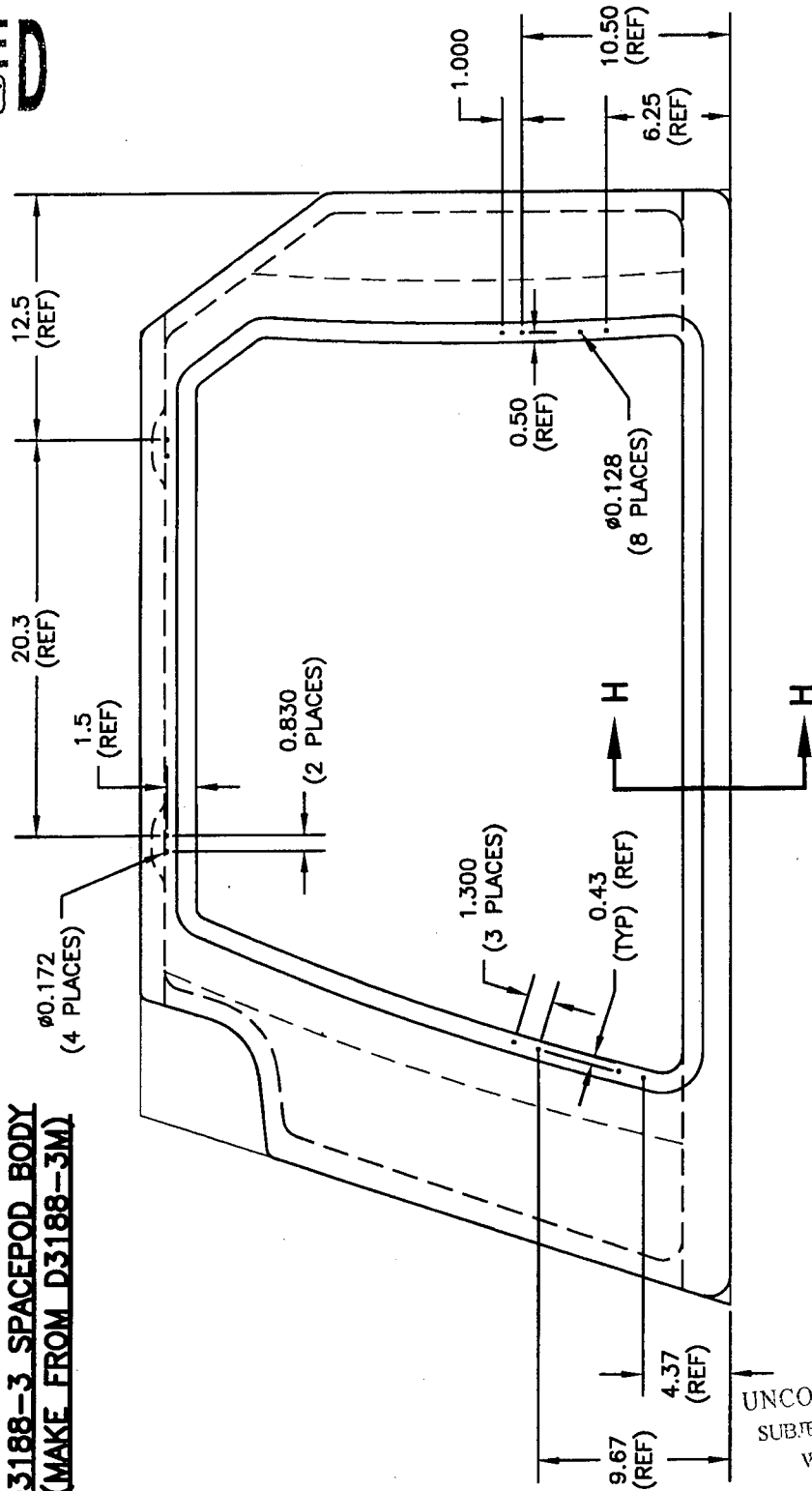


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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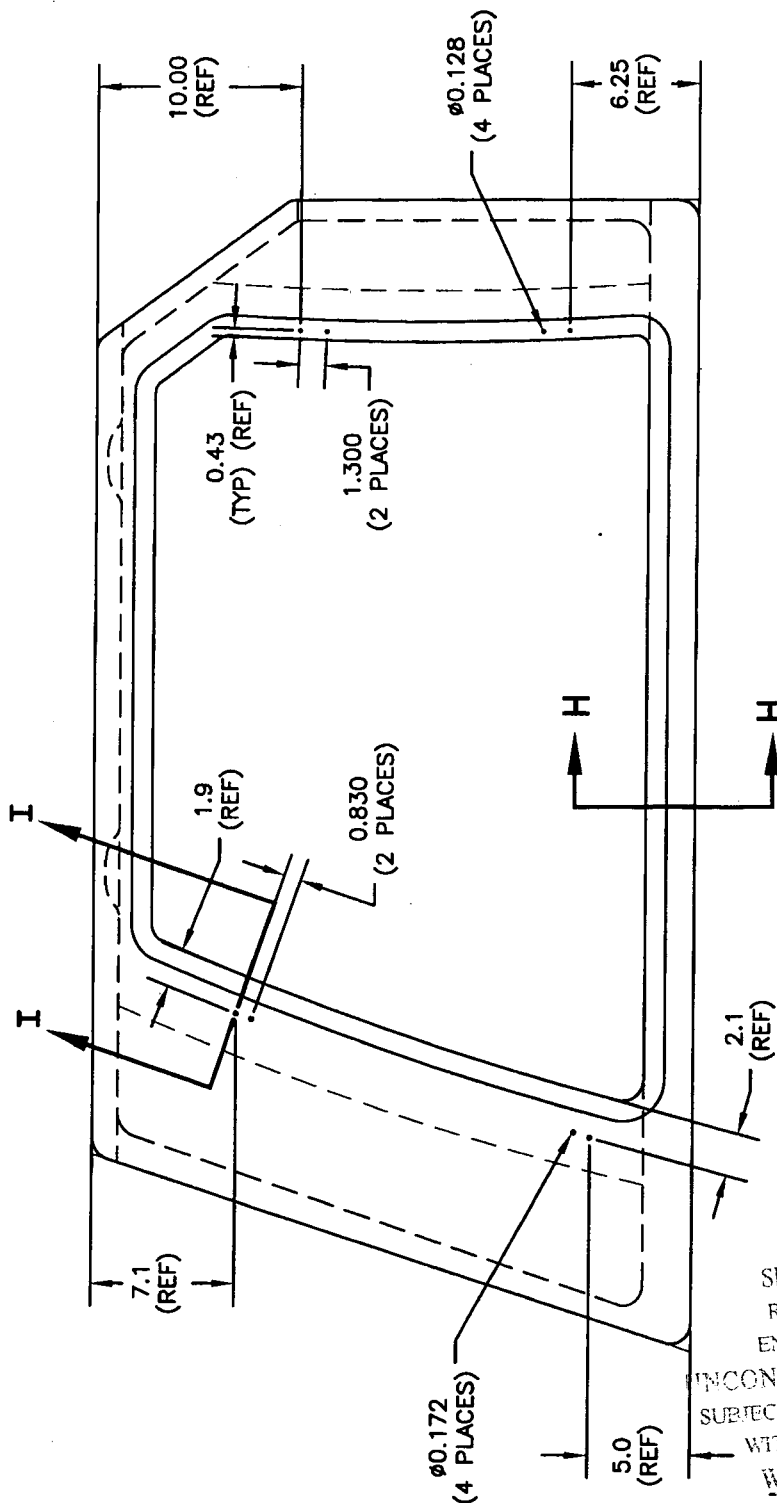
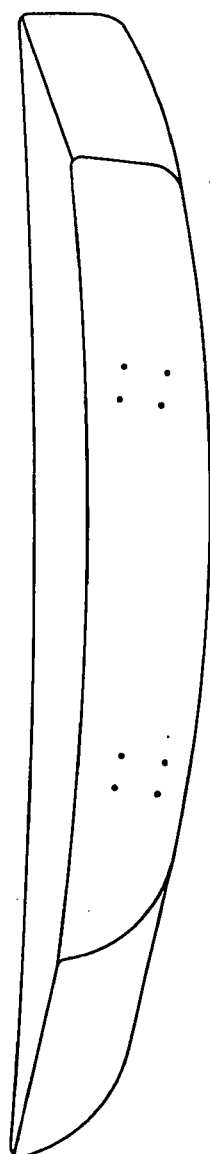
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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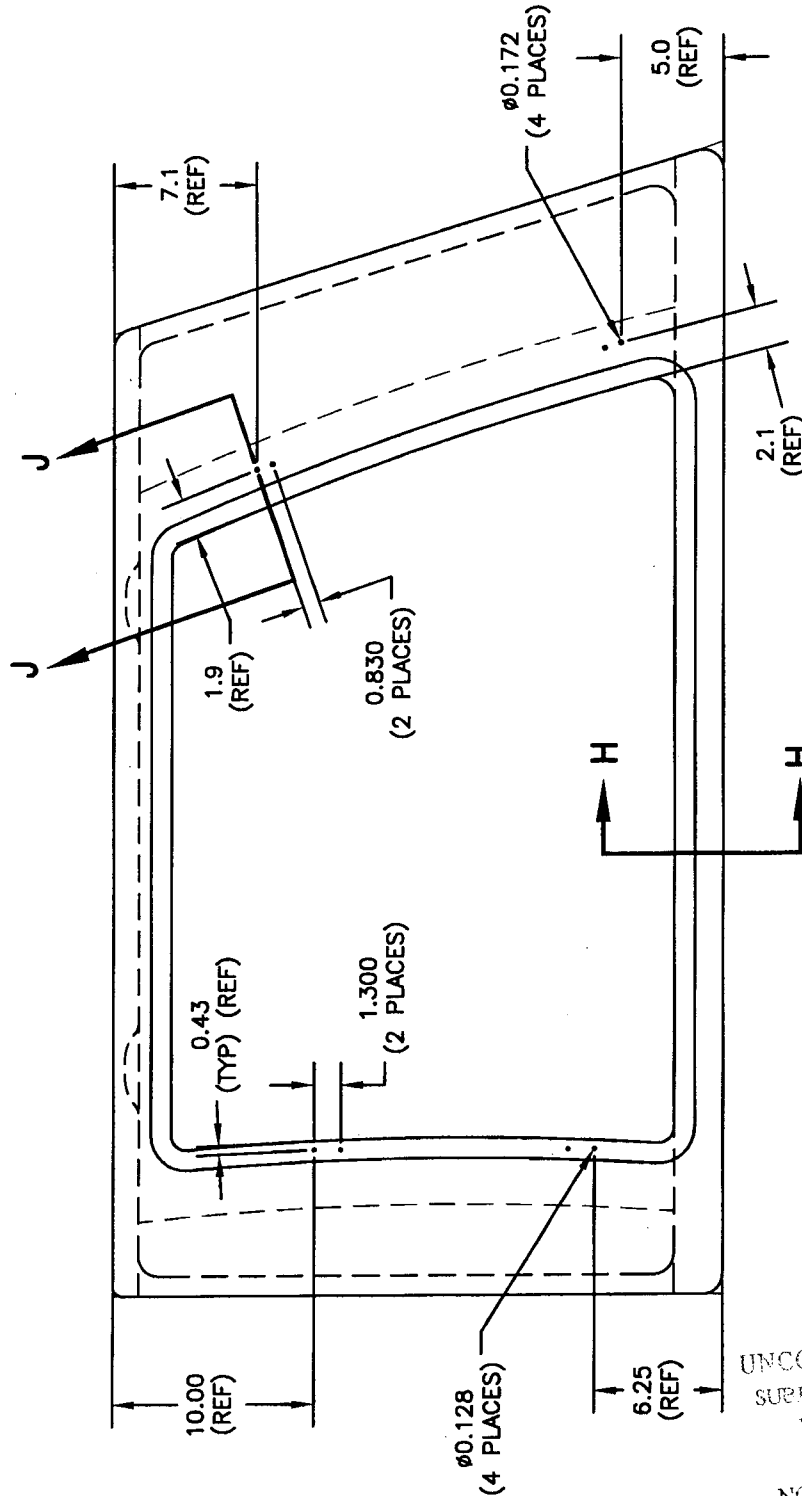
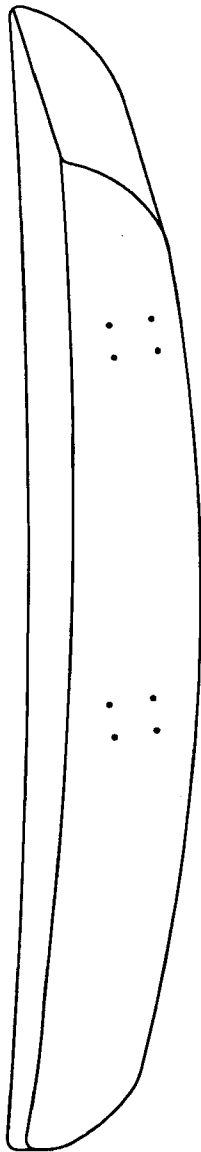
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22 [Signature]

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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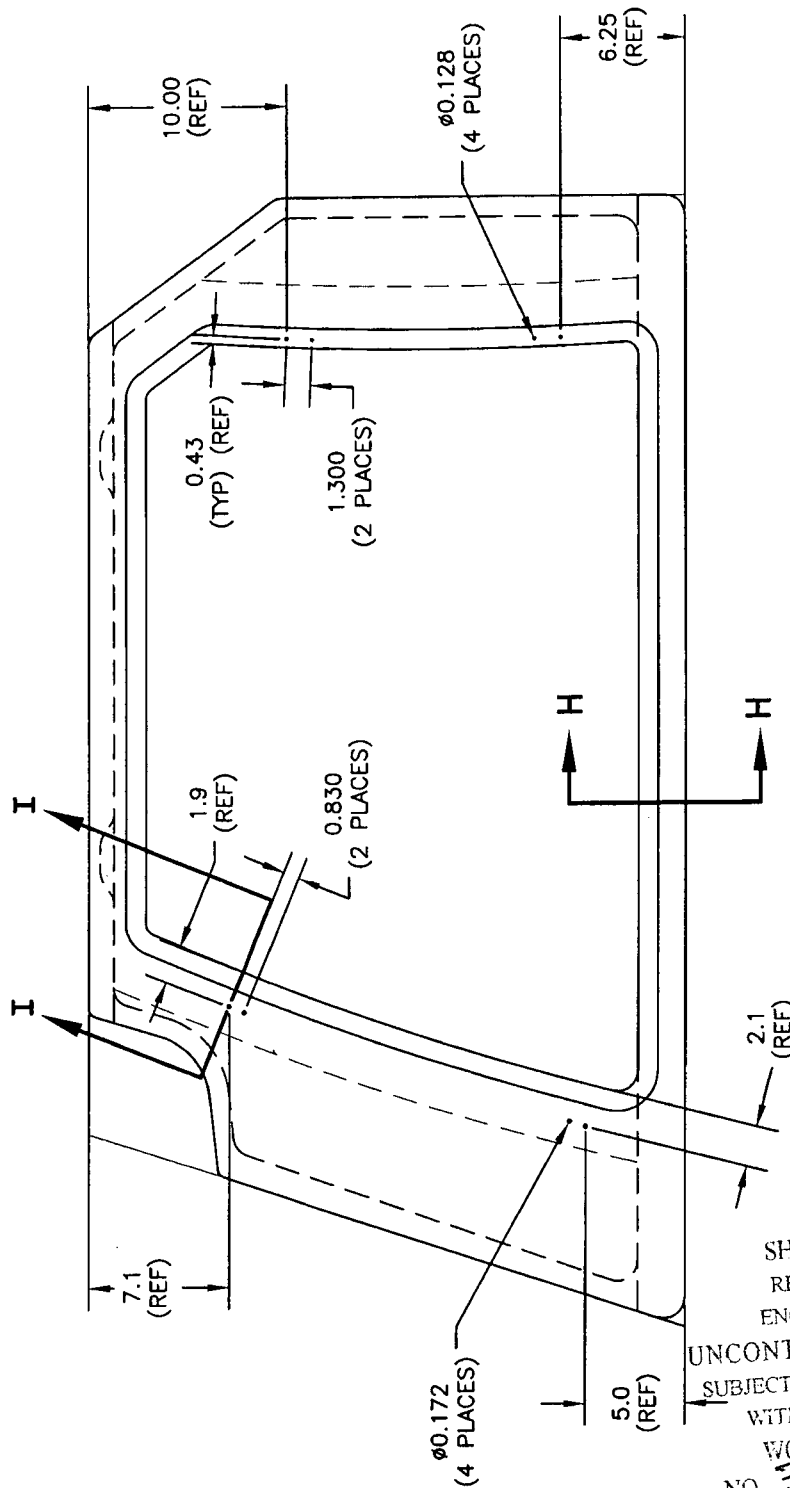
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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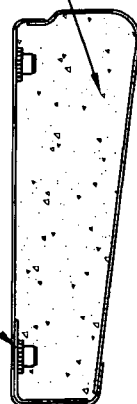


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

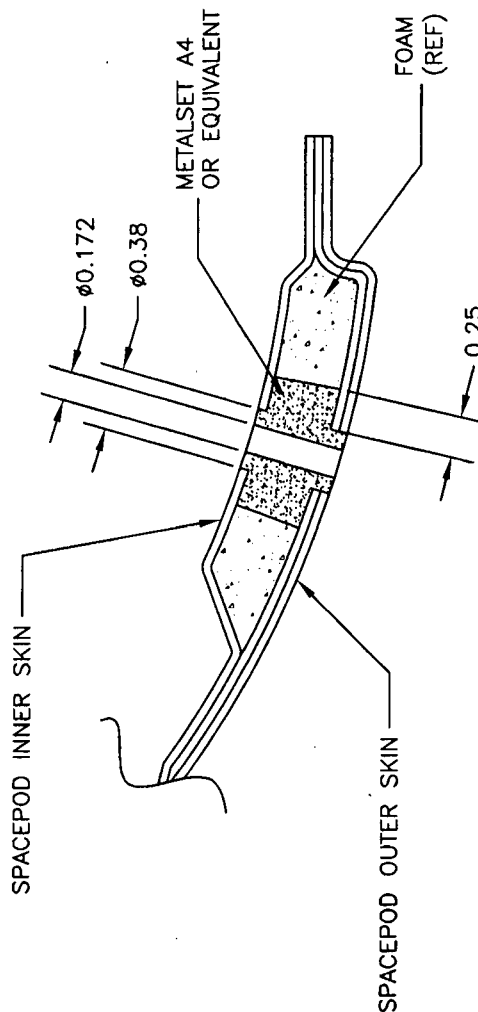
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06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Wednesday, 3/7/2007 2:26:22 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 31048C01		
Estimate Number	: 12599		
P.O. Number	:	Part Number	: D31862M
This Issue	: 3/7/2007 S.O. No. :	Drawing Number	: D3186
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/7/2007 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 30625B01	Material	:
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.03.07</u>		
Comment	: Est Rev:A New Issue 06-12-04 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

w/o 30087

2.0	D31862P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 2:26:22 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 31048C01

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



le 07 26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

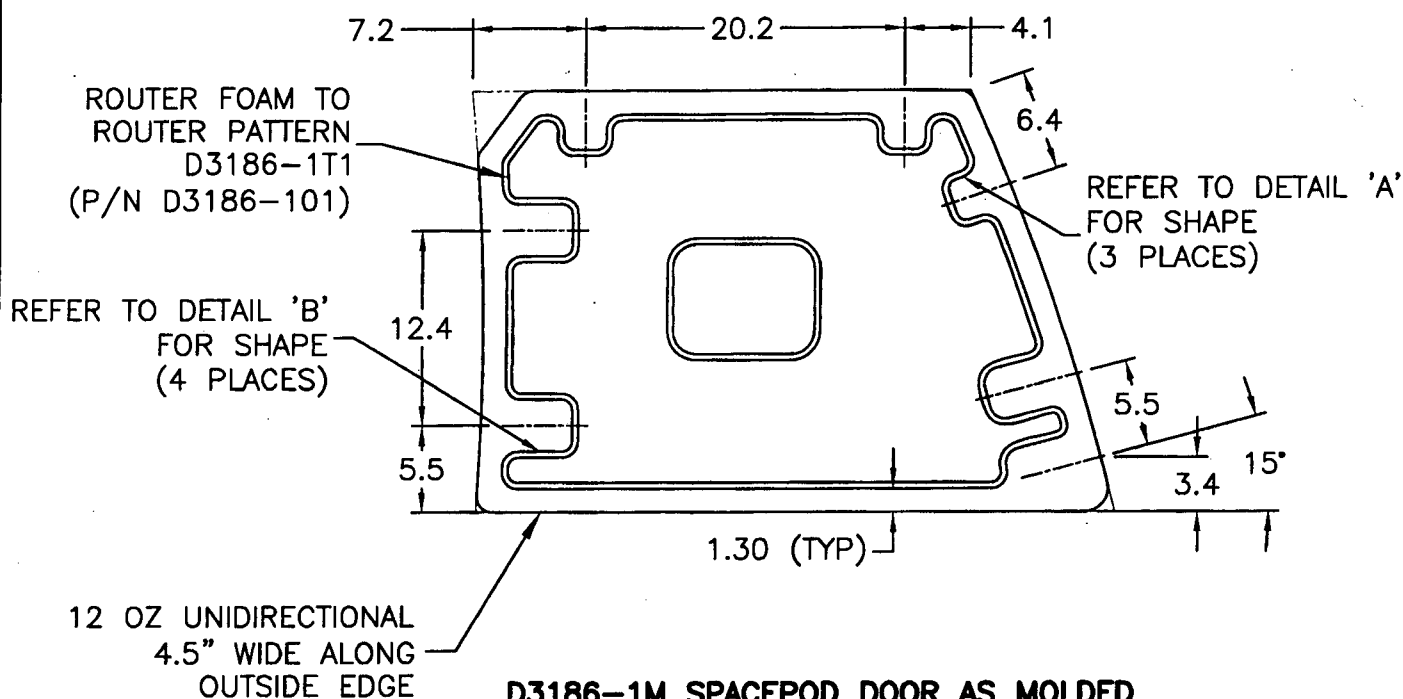
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERA KANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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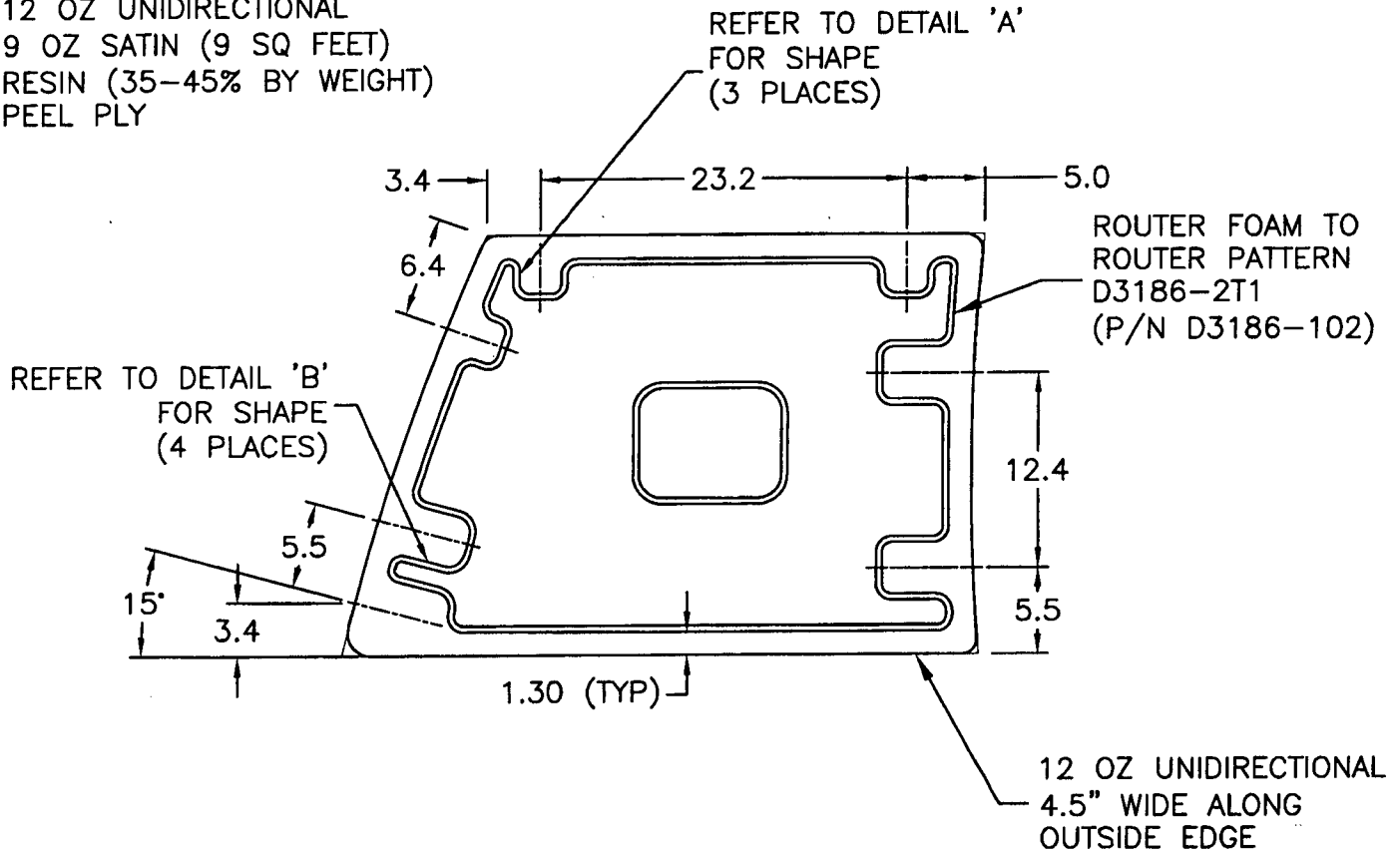
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
06.12.13MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

**D3186-2M SPACEPOD DOOR AS MOLDED**NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
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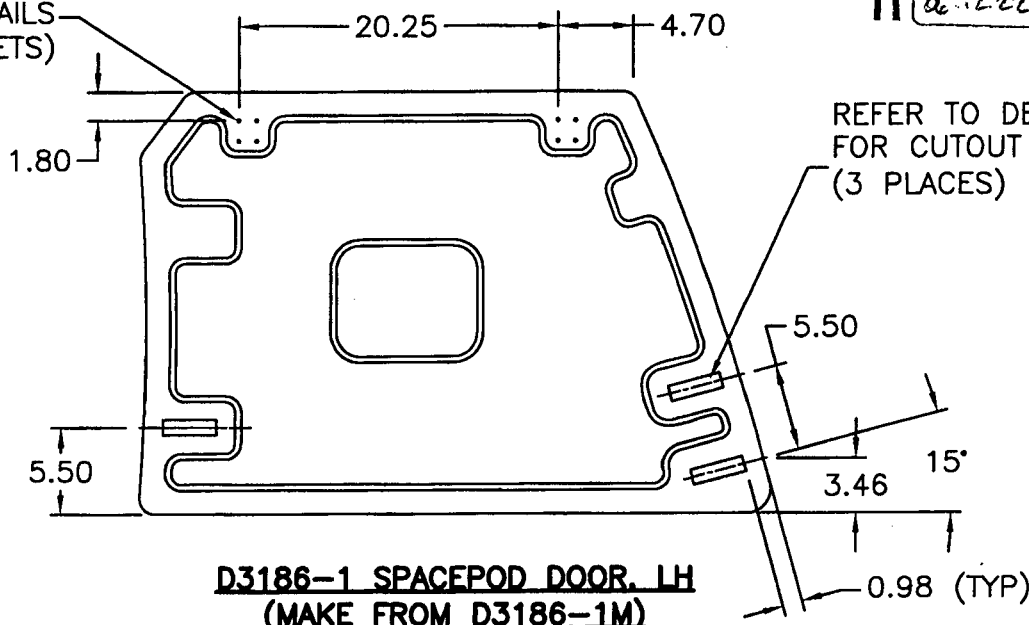
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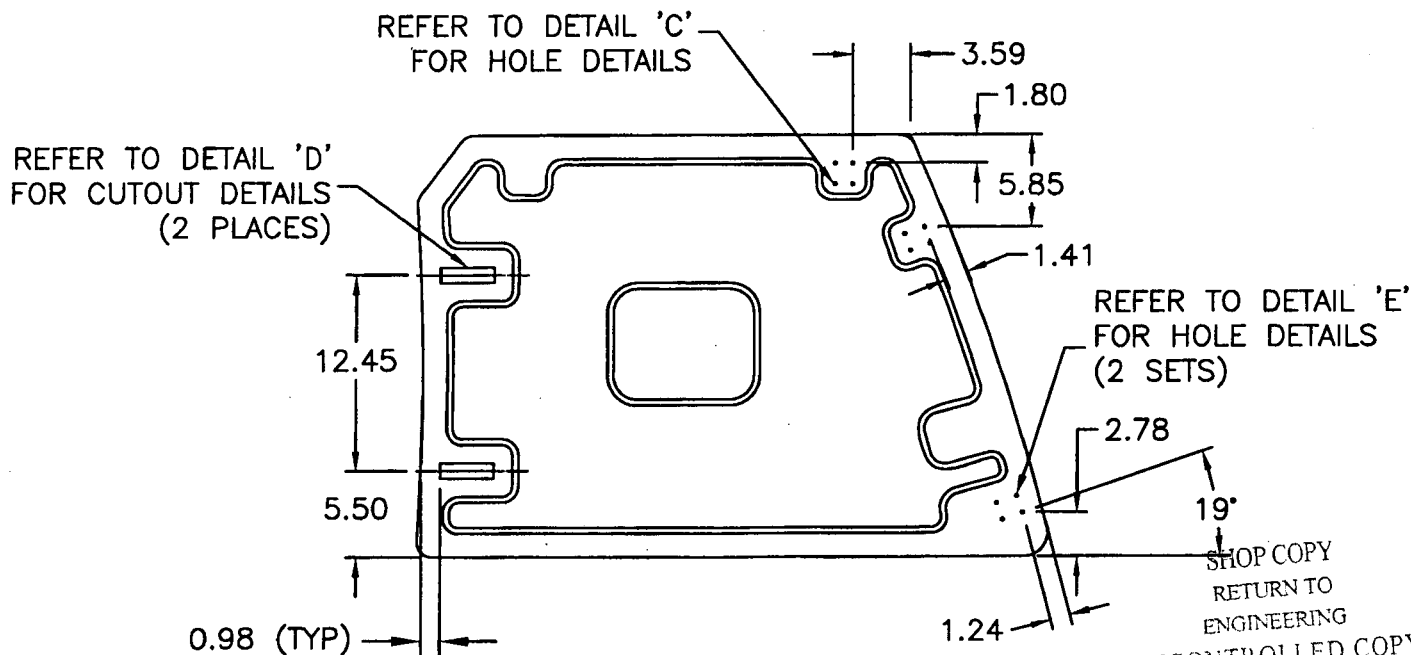
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
ai-222

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)



D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

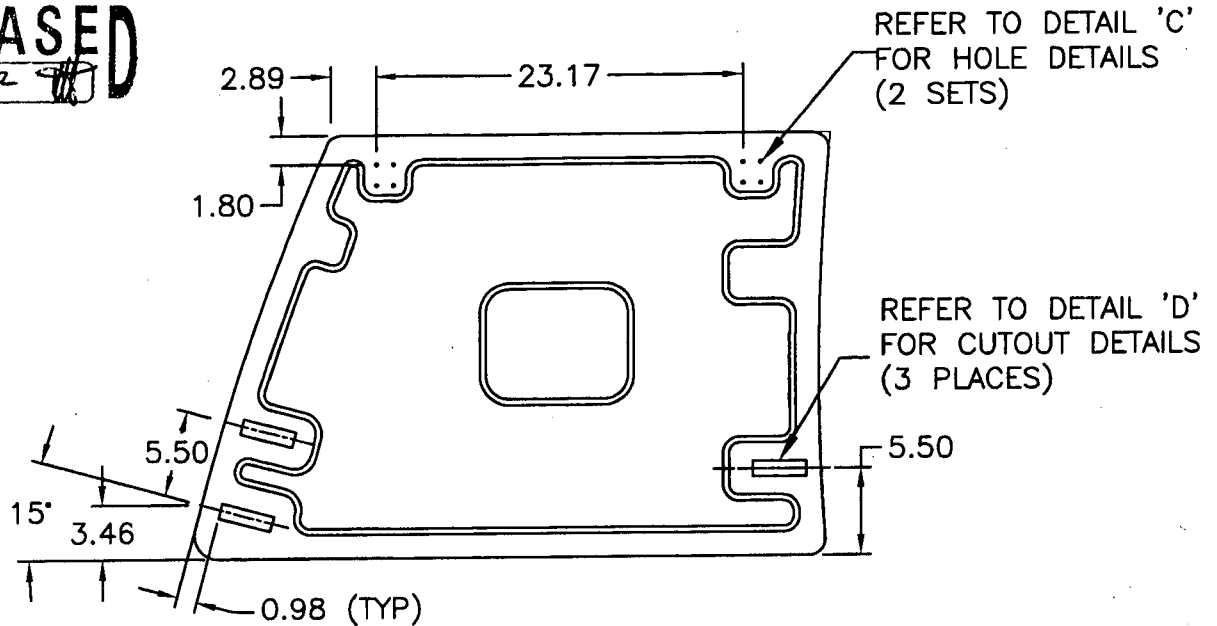
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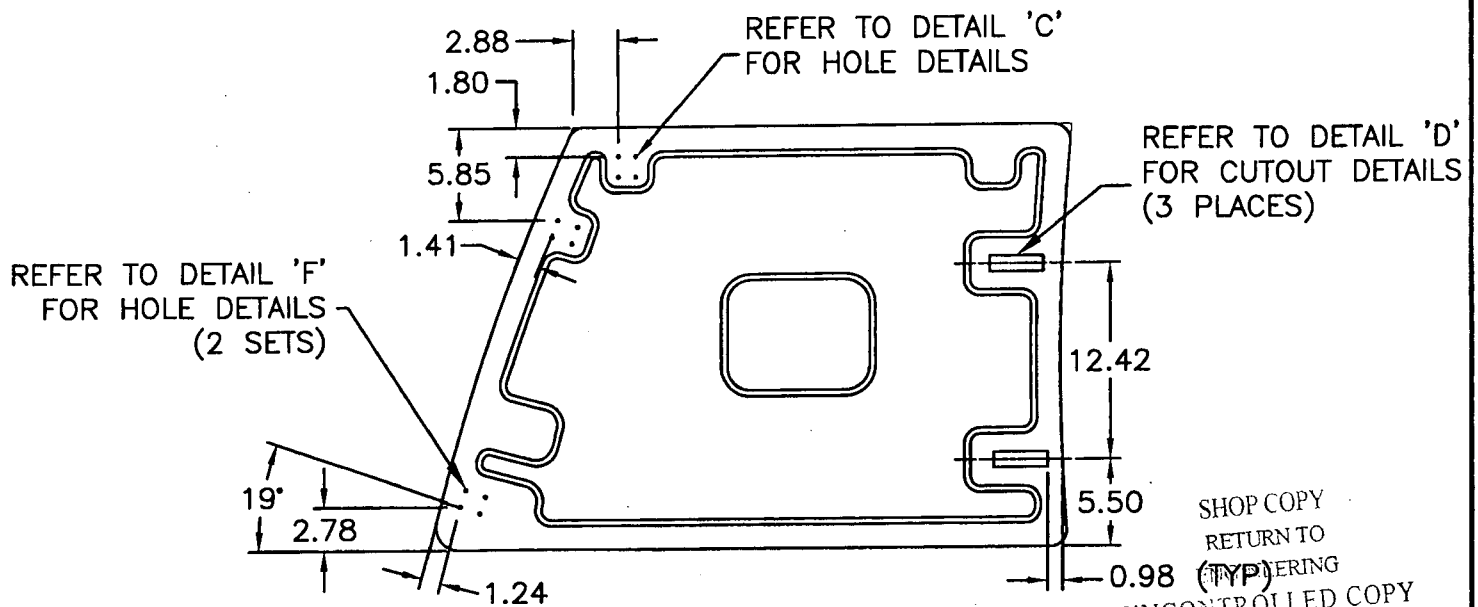
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DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

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06.12.22

D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

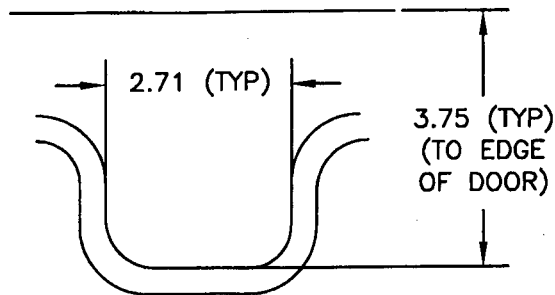
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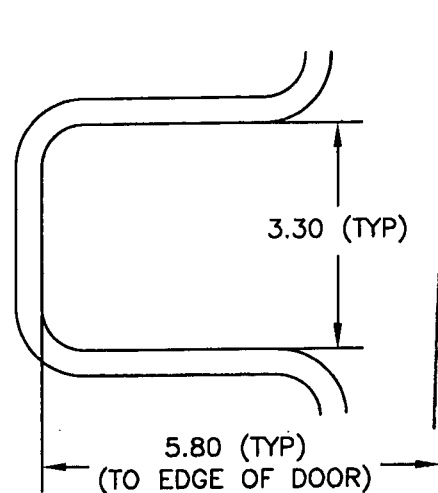
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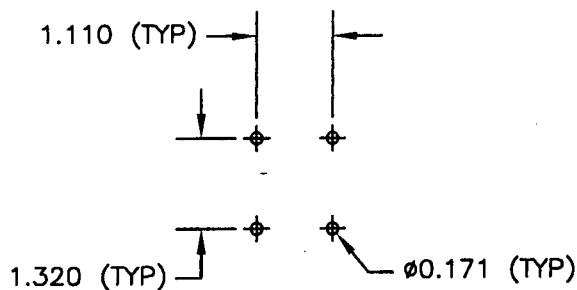
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



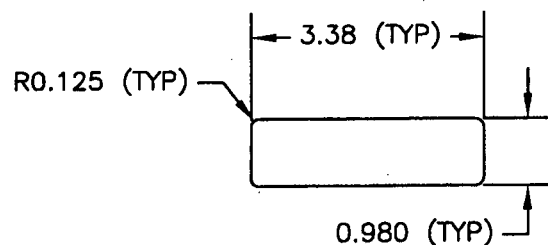
DETAIL A



DETAIL B

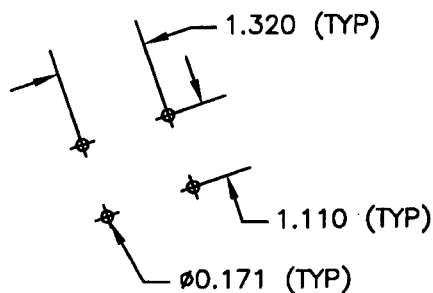


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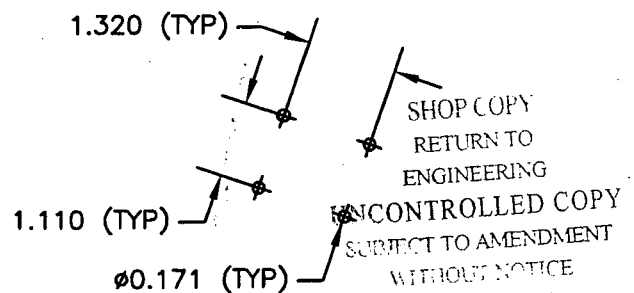


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F NO. 31048C01
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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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Date: Wednesday, 3/7/2007 2:26:14 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SWITCH RELOCATION KIT
Job Number : 31048A	
Estimate Number : 12708	
P.O. Number :	Part Number : D350600349
This Issue : 3/7/2007 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 3/7/2007 Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 31047A	Material :
Written By :	Due Date : 3/30/2007 Qty: 1 Um: Each
Checked & Approved By : <u>07.23.07</u>	
Comment : Est Rev: 07.02.07 new issue ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPP D350-600-349 CHG001

B334360

2.0	M8182412	SPLICE
-----	----------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

SPLICE

3.0	D35971	FEMALE SPADE CONNECTOR
-----	--------	------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

FEMALE SPADE CONNECTOR

4.0	D35982	EXPANDABLE SLEEVE 1/4"
-----	--------	------------------------



Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

EXPANDABLE SLEEVE 1/4"

5.0	D35991	TIE WRAP
-----	--------	----------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

TIE WRAP

6.0	D36001	TIE WRAP MOUNT
-----	--------	----------------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

TIE WRAP MOUNT

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 2:26:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SWITCH RELOCATION KIT

Job Number: 31048A

Part Number: D350600349

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

M2275916229

122GA ELECTRICAL WIRE, 120'



Comment: Qty.: 2.0000 ft(s)/Unit Total : 2.0000 ft(s)
122GA ELECTRICAL WIRE, 120'

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-600-349
Location: _____
PPP Rev: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U *Rev 7.0*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries